



SKRIPSI – ME141501

**ANALISA GETARAN RUANG KAMAR MESIN PADA
KAPAL PENYEBRANGAN KETAPANG – GILIMANUK,
KMP. DHARMA RUCITRA**

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Fakultas Teknologi Kelautan

Institut Teknologi Sepuluh Nopember

Surabaya

2016

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FINAL PROJECT – ME141501

VIBRATION ANALYSIS ENGINE ROOM ON ROUTE KETAPANG – GILIMANUK, KMP. DHARMA RUCITRA

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LEMBAR PENGESAHAN

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SKRIPSI

**Diajukan Untuk Memenuhi Salah Satu Syarat
Memperoleh Gelar Sarjana Teknik
pada
Bidang Studi Marine Machinery and System (MMS)
Program Studi S-1 Jurusan Teknik Sistem Perkapalan
Fakultas Teknologi Kelautan
Institut Teknologi Sepuluh Nopember**

Oleh :

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Disetujui oleh Pembimbing SKRIPSI :

Taufik Fajar Nugroho ST. M.Sc

()

SURABAYA

Juli, 2016

“Halaman Ini Sengaja Dikosongkan”

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Dr. Eng Muhammad Badrus Zaman, ST., MT.
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LEMBAR PENGESAHAN

KELOMPOK PENELITIAN
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KATA PENGANTAR

Penelitian ini bertujuan untuk mengetahui pengaruh dari variabel-variabel yang diteliti. Penelitian ini dilakukan dengan menggunakan metode kuantitatif. Penelitian ini dilakukan dengan menggunakan metode kuantitatif. Penelitian ini dilakukan dengan menggunakan metode kuantitatif. Penelitian ini dilakukan dengan menggunakan metode kuantitatif.

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ANALISA GETARAN RUANG KAMAR MESIN PADA KAPAL PENYEBRANGAN KETAPANG – GILIMANUK, KM. DHARMA RUCITRA

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Abstrak

Getaran adalah sebuah hal yang harus dihindari atau dikurangi, khususnya pada sebuah konstruksi. Karena getaran dapat menimbulkan kerusakan fisik ada sebuah struktur. Seperti kapal, getaran pada kapal haruslah dikurangi atau diminimalisir karena sangat berpengaruh pada konstruk dari kapal tersebut. Pada kasus kali ini KMP. Dharma Rucitra milik PT. Dharma Lautan Utama yang telah dibangun sejak tahun 1980an dimana umur dari kapal tersebut sudah lebih dari 30 tahun, masalah kekuatan dari konstruksi adalah salah satu hal yang menjadi fokus. Oleh sebab itu getaran yang terjadi pada kapal tersebut sangat perlu untuk diperhatikan lebih. Pada kapal sendiri sumber getaran terbesar terjadi pada kamar mesin. Karena sumber getaran pada kapal adalah terletak pada sistem propulsi, yaitu propeller, poros dan mesin induknya.

Proses analisa getaran pada kamar mesin KMP. Dharma Rucitra dilakukan dengan cara perhitungan secara manual dan pengukuran secara langsung pada kamar mesinnya, dimana pengukuran dilakukan pada titik-titik yang telah ditentukan sebelumnya. Hal tersebut dilakukan untuk membandingkan tingkat getaran berdasarkan perhitungan secara manual dan

pengukuran secara langsung dengan standar dan peraturan yang berlaku, ABS, BKI, ISO dan Peraturan Kementrian.

Dari proses analisa tersebut didapatkan bahwa standar yang berhubungan terhadap tingkat getaran pada komponen sistem propulsi masih memenuhi standar ABS. Sedangkan untuk tingkat tegangan atau stress pada poros dan dampak getaran terhadap kenyamanan para pekerja masih tidak memenuhi standar.

Kata Kunci: Getaran, Getaran Torsional, Getaran Longitudinal Sistem Propulsi, Standar, Peraturan

**VIBRATION ANALYSIS ENGINE ROOM
ON ROUTE KETAPANG – GILIMANUK,
KM. DHARMA RUCITRA**

Name : Gathot Dwi Laksono
NRP : 4212100133
Department : Teknik Sistem Perkapalan
Advisor : Taufik Fajar Nugroho, ST, M.Sc

Abstrack

Vibration is a thing to be avoided or reduced, especially at a construction. Because the vibration can cause physical damage there is a structure. Such as ships, vibration on ships must be reduced or minimized because very berpenengaruh on CONSTRUCTS of the ship. In the present case KMP. Dharma Rucitra PT. Dharma Lautan Utama which have been built since the 1980s in which the age of the vessel has more than 30 years, the power problem of construction is one of the things that are the focus. Therefore, the vibration that occurs in the vessel is necessary untu payed more. On the largest ship itself the source of vibration occurs in the engine room. Because the source of vibration in the news are located on the propulsion system, the propeller, shaft and the parent machine.

The process of vibration analysis on KMP engine room. Dharma Rucitra done by manual calculation and measurement directly in the engine room, where the measurements are made at points predetermined. It tersebeut conducted to compare the level of vibration by manual calculation and direct measurement with

the standards and regulations, ABS, BKI, ISO and Regulation Ministry.

From this analysis it was found that the process of standards relating to the level of vibration in the propulsion system components meet the standard ABS. As for the level of tension or stress on the shaft and the impact of vibration on the comfort of the workers still do not meet the standards.

Keyword: Vibration, Longitudinal Vibration, Torsional Vibration, Propulsion System, Standard, Rules.

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Puji syukur Alhamdulillah penulis panjatkan kehadirat ALLAH SWT yang telah memberikan rahmat serta karunia-Nya kepada kami sehingga berhasil menyelesaikan skripsi ini dengan baik dengan judul **“ANALISA GETARAN KAMAR MESIN PADA KAPAL PENYEBRANGAN KETAPANG – GILIMANUK, KMP. DHARMA RUCITRA”**.

Pada penyusunan skripsi ini, banyak bantuan, bimbingan, serta dorongan motivasi dari berbagai pihak yang diberikan pada penulis. Oleh karena itu, dengan segala kerendahan hati penulis mengucapkan terimakasih kepada :

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Surabaya, Juli 2016

DAFTAR ISI

Halaman Judul	i
Lembar Pengesahan	iii
Abstrak	v
Abstrak	vii
Kata Pengantar	xi
Daftar Isi	xi
Daftar Gambar	xv
Daftar Tabel	xvii
Daftar Grafik	xix

BAB I PENDAHULUAN

1

1.1 Latar Belakang	1
1.2 Perumusan Masalah.....	2
1.3 Batasan Masalah	3
1.4 Tujuan	3
1.5 Manfaat	3

BAB II TINJAUAN PUSTAKA

5

2.1 Pengertian Getaran.....	7
2.2 Bentuk Getaran.....	8
2.3 Getaran Longitudinal pada Sistem Propulsi.....	8
2.4 Getaran Torsional pada Sistem Propulsi	17
2.5 Tegangan Getaran Torsional.....	21
2.6 Pengukuran Getaran	24
2.7 Standar Internasional dan Peraturan Pemerintah.....	25
2.7.1 ABS (American Bureau of Shipping).....	25
2.7.2 ISO 2631.....	26
2.7.3 KEPMENAKER No.51. Tahun 1999.....	27

2.7.4 BKI (Biro Klasifikasi Indonesia).....	27
BAB III METODOLOGI	29
3.1 Umum	29
3.2 Studi Literatur.....	29
3.3 Pengumpulan Data.....	25
3.4 Perhitungan Getaran.....	32
3.5 Perhitungan Tegangan Torsional	33
3.6 Pengukuran Getaran.....	33
3.6.1 Tata Cara Pemakaian <i>Vibration Meter</i>	34
3.7 Penentuan Titik Pengukuran	35
3.8 Pengecekan Standar dan Peraturan Pemerintah.....	36
3.9 Analisa Data.....	37
3.10 Kesimpulan dan Saran.....	37
3.11 Flow Chart Metodologi Penelitian	38
BAB IV ANALISA DAN PEMBAHASAN	41
4.1 Analisa Getaran.....	41
4.2 Perhitungan Getaran.....	41
4.2.1 Getaran Longitudinal Sistem Propusi	42
4.2.2 Getaran Torsional Sistem Propusi	54
4.3 Perhitungan Tegangan Getaran Torsional	61
4.4 Pengukuran Getaran.....	63
4.5 Pengecekan Standart dan Aturan.....	79
4.5.1 Pengecekan Standart dan Aturan Getaran	79
4.5.1.1 ABS.....	79
4.5.1.2 ISO 2631.....	83
4.5.1.3 KEPMENAKER No. 51 Tahun 1999.....	84
4.5.2 Pengecekan Standar Tegangan Getaran Torsional	88
4.6 Pengurangan Tingkat Getaran.....	90

4.7 Pengurangan Tingkat Stress Getaran Torsional	91
BAB V KESIMPULAN DAN SARAN	93
5.1 Kesimpulan	93
5.2 Saran	94
DAFTAR PUSTAKA	95

“Halaman Ini Sengaja Dikosongkan”

DAFTAR GAMBAR

Gambar 2.1 Simpul Getar.	6
Gambar 2.2 Model matematis getaran longitudinal sistem propulsi.....	8
Gambar 2.3 Batas tegangan yang diizinkan pada <i>intermediate shaft</i>	28
Gambar 2.4 Batas tegangan yang diizinkan pada <i>propeller</i> <i>shaft</i>	28
Gambar 3.1 KMP. Dharma Rucitra.....	30
Gambar 3.2 Mesin induk KMP. Dharma Rucitra.....	31
Gambar 3.3 <i>Vibration meter Lutron VB-8200</i>	33
Gambar 3.4 Titik – titik pengukuran getaran.....	36
Gambar 4.1 Model getaran longitudinal sistem propulsi.....	42
Gambar 4.2 Getaran torsional.....	55
Gambar 4.3 Pondasi mesin induk.....	64
Gambar 4.4 <i>Clutch</i>	64
Gambar 4.5 <i>Plumer block</i>	65
Gambar 4.6 Titik- titik pengukuran tingkat getaran	65
Gambar 4.7 Nilai ambang batas tegangan pada poros akibat getaran torsional.....	89
Gambar 4.8 <i>Engine Struts</i>	90

“Halaman Ini Sengaja Dikosongkan”

DAFTAR TABEL

Tabel 2.1	Nilai ambang batas getaran pada mesin propulsi.....	26
Tabel 2.2	Nilai ambang bats getaran terhadap ABK Kapal..	26
Tabel 2.3	Nilai ambang batas getaran terhadap tubuh bagi bagi pekerja..	27
Tabel 2.4	Nilai Ambang batas getaran menurut kuputusan menteri tenaga kerja no.51 tahun 1999.....	27
Tabel 3.1	Identitas kapal.....	30
Tabel 3.2	Ukuran utama kapal.....	31
Tabel 3.3	Data kapasitas muat.....	31
Tabel 3.4	Data utama mesin induk.....	32
Tabel 3.5	Spesifikasi alat pengukur getaran.....	34
Tabel 4.1	Data pengukuran getaran pada titik 1 hingga 10.....	66
Tabel 4.2	Data pengukuran getaran pada titik 11 hingga 20.....	67
Tabel 4.3	Hasil rata-rata tingkat getaran.....	78
Tabel 4.4	Nilai ambang batas getaran pada mesin propulsi.....	81
Tabel 4.5	Perbandingan nilai hasil pengukuran terhadap standart ABS.....	81
Tabel 4.6	Nilai ambang batas getaran terhadap ABK.....	82

Tabel 4.7	Nilai ambang batas getaran terhadap tubuh bagi pekerja.....	83
Tabel 4.8	Nilai ambang batas getaran menurut keputusan menteri tenaga kerja no.51 thn.1999.....	84

DAFTAR GRAFIK

Tabel 4.1	Data pengukuran getaran pada titik 1.....	68
Tabel 4.2	Data pengukuran getaran pada titik 2.....	68
Tabel 4.3	Data pengukuran getaran pada titik 3.....	69
Tabel 4.4	Data pengukuran getaran pada titik 4.....	69
Tabel 4.5	Data pengukuran getaran pada titik 5.....	70
Tabel 4.6	Data pengukuran getaran pada titik 6.....	70
Tabel 4.7	Data pengukuran getaran pada titik 7.....	71
Tabel 4.8	Data pengukuran getaran pada titik 8.....	71
Tabel 4.9	Data pengukuran getaran pada titik 9.....	72
Tabel 4.10	Data pengukuran getaran pada titik 10.....	72
Tabel 4.11	Data pengukuran getaran pada titik 11.....	73
Tabel 4.12	Data pengukuran getaran pada titik 12.....	73
Tabel 4.13	Data pengukuran getaran pada titik 13.....	74
Tabel 4.14	Data pengukuran getaran pada titik 14.....	74
Tabel 4.15	Data pengukuran getaran pada titik 15.....	75
Tabel 4.16	Data pengukuran getaran pada titik 16.....	75
Tabel 4.17	Data pengukuran getaran pada titik 17.....	76
Tabel 4.18	Data pengukuran getaran pada titik 18.....	76
Tabel 4.19	Data pengukuran getaran pada titik 19.....	77
Tabel 4.20	Data pengukuran getaran pada titik 20.....	77
Tabel 4.21	Perbandingan hasil perhitungan manual getaran secara manual dengan standar ABS.....	85
Tabel 4.22	Perbandingan hasil pengukuran getaran dengan standar ABS (1).....	86
Tabel 4.23	Perbandingan hasil pengukuran getaran dengan standar ABS (2).....	86

Tabel 4.24 Perbandingan rata-rata hasil pengukuran terhadap kenyamanan bagi pekerja... ..	88
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BAB I

PENDAHULUAN

1.1. LATAR BELAKANG

Sebagai negara maritim, kapal merupakan salah satu transportasi utama di negara Indonesia untuk menuju atau mencapai tempat yang kita tuju. Oleh karena itu industri kapal di Indonesia cukup maju, dan untuk dapat mampu bersaing dengan industri perkapalan di luar negeri harus mampu meningkatkan kualitas pelayanan dan kapal. Untuk meningkatkan kualitas kapal salah satunya dengan menjaga kualitas kapal pada kondisi terbaik melalui proses perawatan dan pengecekan standar, salah satunya pengecekan standar resonansi getaran.

Getaran pada kapal sangat berpengaruh terhadap kerusakan fisik struktur konstruksi serta pengaruh tingkat kenyamanan dalam operasional selama di kapal. Untuk menganalisa getaran yang timbul akibat adanya pengaruh frekuensi eksitasi terhadap frekuensi natural yang terjadi maka harus ditinjau gaya dinamis yang bekerja.

Untuk mengurangi getaran yang terjadi agar dapat meningkatkan kenyamanan kapal, oleh karena itu dalam pembuatan kapal harus disesuaikan oleh standar yang berlaku, yaitu standar ISO, Keputusan Menteri Tenaga Kerja RI, BKI dan ABS. Tingkat getaran yang terjadi di kapal berubah sesuai dengan kondisi kapal. Untuk itu perlu dilakukan pengecekan, apakah kapal tersebut sudah sesuai dengan standar yang telah ditetapkan.

1.2. PERUMUSAN MASALAH

Dari uraian di atas maka permasalahan utama yang akan dibahas adalah sebagai berikut :

1. Bagaimana cara menganalisa getaran pada kamar mesin
2. Bagaimana cara menganalisa getaran longitudinal sistem propulsi pada kapal KMP. Dharma Rucitra.
3. Bagaimana cara menganalisa getaran torsional sistem propulsi pada kapal KMP. Dharma Rucitra.
4. Bagaimana cara menganalisa tingkat stress pada shaft akibat dari getaran torsional.
5. Bagaimana menentukan tingkat getaran yang sesuai dengan standar yang berlaku.
6. Bagaimana menentukan tingkat stress komponen akibat getaran sesuai standar yang berlaku.
7. Bagaimana langkah cara mengurangi tingkat getaran.
8. Bagaimana langkah cara mengurangi tingkat stress komponen.

1.3. BATASAN MASALAH

Untuk dapat merealisasikan penulisan tugas akhir ini, maka diperlukannya pembatasan-pembatasan sebagai berikut:

1. Analisa getaran hanya dilakukan pada ruang kamar mesin KMP. Dharma Rucitra, kapal penyebrangan Ketapang – Gilimanuk.
2. Pengukuran dilakukan secara langsung pada sistem propulsi yang terdapat pada ruang kamar mesin KMP. Dharma Rucitra, kapal penyebrangan Ketapang – Gilimanuk.
3. Tidak membahas gelombang laut sebagai sumber eksitasi.
4. Tidak membahas dampak gelombang laut terhadap awak kapal dan penumpang.

1.4. TUJUAN

1. Mengetahui cara menganalisa getaran pada kamar mesin.
2. Menganalisa tingkat getaran longitudinal pada sistem propulsi.
3. Menganalisa tingkat getaran torsional pada sistem propulsi.
4. Mengetahui tingkat stress pada poros propeller akibat dari getaran torsional.
5. Membandingkan tingkat getaran hasil pengukuran secara langsung dan perhitungan manual terhadap standar yang berlaku.
6. Membandingkan tingkat stress getaran torsional terhadap standar yang berlaku.
7. Mengetahui cara menurunkan tingkat getaran
8. Mengetahui cara menurunkan tingkat tegangan akibat getaran torsional.

1.5. MANFAAT

1. Memberikan informasi atau kontribusi pada penelitian lebih lanjut untuk peningkatan kualitas kenyamanan pada kapal yang dijadikan objek pengambilan data.
2. Mengetahui langkah-langkah untuk mengurangi getaran.
3. Mengetahui langkah-langkah untuk mengurangi tegangan getaran torsional.

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BAB II

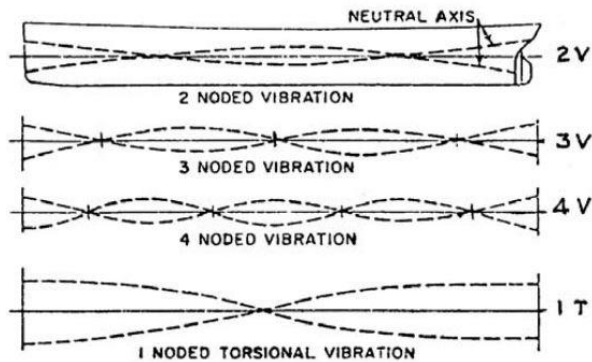
TINJAUAN PUSTAKA

2.1. PENGERTIAN GETARAN

Getaran merupakan sebuah respon dari sebuah sistem mekanik, baik disebabkan oleh gaya eksitasi yang diberikan maupun perubahan kondisi operasi sebagai fungsi waktu.

Getaran terjadi akibat dari transfer gaya siklik melalui elemen - elemen pada mesin yang ada, dimana elemen tersebut saling beraksi antara satu dengan yang lainnya dan energi didisipasi melalui struktur dalam bentuk getaran. Kerusakan atau keausan serta deformasi akan merubah karakteristik dinamik sistem dan cenderung meningkatkan energi getaran. Sedangkan gaya yang menyebabkan getaran dapat ditimbulkan oleh beberapa sumber kontak benturan antara komponen yang bergerak atau berputar. Putaran dari massa yang tidak seimbang (*unballance mass*), tidak sejajar atau searah (*miss alignment*) dan juga karena kerusakan bantalan (*bearing fault*). Berikut merupakan beberapa istilah dalam getaran:

- ✓ **Frekuensi (f)** adalah jumlah getaran yang berjalan persatuan waktu.
- ✓ **Amplitudo (A)** adalah jarak terjauh yang ditimbulkan dari sebuah respon getaran dalam satuan jarak (meter).
- ✓ **Frekuensi Natural** adalah frekuensi yang dirangsang secara tidak disengaja (*natural*) dari posisi awal.
- ✓ **Simpul Getar** adalah titik nol pada sebuah distribusi perpindahan getaran.



Gambar 2.1: Simpul Getar

(Principles of Naval Architecture Series: Vibration)

- ✓ **Getaran Eksitasi** adalah sebuah gaya luar yang diberikan pada sebuah sistem sehingga menyebabkan sistem tersebut bergetar.
- ✓ **Frekuensi Eksitasi** adalah jumlah getaran eksitasi dalam sebuah periode getar persatuan waktu,
- ✓ **Resonansi** adalah kondisi yang terjadi akibat dari getaran eksitasi bergetar secara bersamaan dengan salah satu sistem frekuensi natural.
- ✓ **Bandwidth** adalah jarak dari frekuensi getaran atau kebisingan pada saat terjadi.
- ✓ **Tempo** adalah karakteristik dari sistem eksitasi karena dua atau lebih frekuensi eksitasi.

Suatu struktur mekanik yang mengalami gaya eksitasi akan bergetar pada salah satu atau pada beberapa frekuensi natural. Frekuensi natural itu sendiri berpengaruh terhadap rentang ukur frekuensi suatu percepatan atau kecepatan. Frekuensi natural dari masing-masing sistem struktur dengan pendekatan matematik

yaitu implikasinya dengan formula teori getaran. Besarnya frekuensi natural dapat ditabulasikan, besarnya harga frekuensi eksitasi (ω) dapat dicari berdasarkan pada putaran motor perwaktu (RPM) dari teori getaran perbandingan frekuensi natural (ω_n) dan frekuensi eksitasi.

2.2. BENTUK GETARAN

Secara umum terdapat dua jenis getaran yaitu getaran bebas dan getaran paksa. Getaran bebas adalah getaran yang terjadi karena sistem berosilasi akibat dari berkerjanya gaya yang ada pada sistem itu sendiri dan jika tidak ada gaya luar yang berkerja. Sebuah sistem yang bergetar bebas akan bergetar pada satu atau lebih frekuensi naturalnya yang merupakan sifat dari sistem dinamika yang dibentuk oleh distribusi masa dan kekuan dari sistem tersebut.

Getaran paksa adalah getaran yang terjadi karena rangsangan gaya luar. Maksudnya gaya luar berosilasi dengan sistem, sehingga menyebabkan sistem dipaksa untuk bergetar pada frekuensi rangsangan. Jika sebuah sistem dipengaruhi oleh gerak harmonik paksa, maka respon getarannya akan berlangsung pada frekuensi yang sama dengan frekuensi eksitasinya.

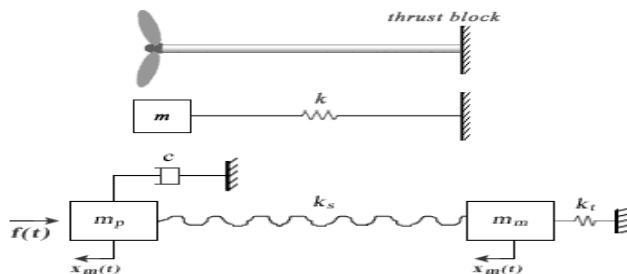
Sumber - sumber eksitasi harmonik adalah ketidak keseimbangan pada elemen – elemen mesin yang berputar, gaya - gaya yang dihasilkan oleh gerak torak atau gerak mesin itu sendiri. Eksitasi ini sendiri yang dapat mengganggu operasi mesin itu sendiri atau dapat mengganggu, merusak dari struktur mesin apabila amplitudo getarannya yang besar. Dalam banyak hal, resonansi harus dihindari dan untuk mencegah berkembangnya amplitudo yang lebih besar, maka oleh karena itu sering kali digunakan peredam (*dumper*) dan penyerap (*absorber*).

Pada kapal getaran paksa biasa terjadi pada kamar mesin. Tepatnya pada pondasi mesin induk (*main engine*). Ini disebabkan mesin induk yang bertumpu di atasnya bergetar. Apabila frekuensi rangsangannya sama dengan frekuensi natural sistem, maka akan menyebabkan resonansi dan osilasi besar yang berbahaya mungkin terjadi.

2.3. GETARAN LONGITUDINAL PADA SISTEM PROPULSI

Getaran longitudinal pada sistem propulsi kapal merupakan salah satu getaran dengan koordinat gerak sejajar dengan sumbu poros *propeller*. Getaran ini timbul akibat putaran *propeller* serta adanya gerakan radial dari *main engine*.

Gaya aksial *propeller* (*thrust*) ditahan oleh *thrust block* yang kemudian diteruskan ke konstruksi kapal (pondasi *main engine*). Akibat dari gaya aksial *propeller* tersebut maka *thrust block* dan pondasinya akan mengalami pergeseran secara longitudinal. Untuk analisa getaran longitudinal sistem propulsi kapal dapat dimodelkan sebagai suatu sistem pegas massa, seperti ditunjukkan pada gambar 2.2.



Gambar 2.2 Model matematis getaran longitudinal sistem propulsi.

(<http://ftk-its.info/elearn/long1.htm>)

Sistem propulsi akan bergetar longitudinal pada posisi *thrust block*. Jika seluruh sistem dari *propeller* sampai mesin dianggap sebagai kesatuan massa tegar, maka semua titik pada sistem tersebut akan bergetar dengan besar perpindahan aksial yang sama, sebesar $x(t)$. Dari gambar tersebut, m adalah massa total dari sistem, termasuk penambahan massa akibat massa air laut yang ikut dengan sistem. Penambahan massa (Δm) tersebut sangat tergantung dari tipe dan dimensi *propeller*. Sedangkan K adalah kekakuan *thrust bearing*. Nilai K sendiri merupakan kombinasi dari kekakuan *thrust block* (K_B) dan kekakuan pondasi atau *thrust block seating* (K_S). Hubungan tersebut diberikan dengan persamaan 2.1:

$$\frac{1}{K} = \frac{1}{K_B} + \frac{1}{K_S} \quad (2.1)$$

K_B tergantung dari tipe *bearing* dan dapat dibagi ke dalam beberapa komponen seperti, *thrust collar*, *oil film*, *thrust pad* dan kekakuan *housing*. K_S ditentukan oleh kekuatan dari *thrust block seating* dan struktur bagian tengahnya terutama pada panjang, ketebalan, tinggi dan jumlah elemen struktur longitudinal. K_S juga dapat dipengaruhi oleh kekakuan geser dari *housing* dan *thrust block seating*, terutama untuk kasus dimana jarak antara poros dan *double bottom* perlu diperhitungkan. Untuk penempatan *thrust block* yang menyatu langsung dengan mesin induk, maka nilai estimasi dari K_B ditentukan secara langsung dengan instalasi mesin tersebut.

Langkah awal dalam proses analisa getaran longitudinal adalah menentukan frekuensi natural sistem. Hal ini diperlukan untuk mengetahui apakah frekuensi natural sistem sama dengan salah satu frekuensi eksitasi dari sumber getar. Perlu diingat

sumber getar pada sistem cukuplah banyak, meskipun tidak semuanya mempunyai kontribusi terhadap persoalan yang ditinjau.

Dari pemodelan sistem, frekuensi natural sistem (Hz) dapat dihitung dengan menggunakan persamaan 2.2:

$$f_n = \frac{1}{2\pi} \sqrt{\frac{K}{M}} \quad (2.2)$$

Dimana:

K : Kekakuan pegas (N/m)

M : Massa (Kg)

Untuk nilai K itu sendiri dapat dicari dengan menggunakan persamaan 2.3:

$$K = \frac{E \times A}{l} \quad (2.3)$$

Dimana:

E : Modulus elastisitas (N/m^2)

A : Luas penampang dari *thrust block* (m^2)

l : Panjang *thrust block* (m)

Nilai frekuensi natural yang telah diperoleh lalu dibandingkan dengan frekuensi eksitasi untuk mengetahui apakah ada kemungkinan terjadinya resonansi. Oleh sebab itu harus dilihat terlebih dahulu sumber getaran dari sistem yang sedang dianalisa. Beberapa kemungkinan sumber getaran adalah:

1. Gelombang Laut.

Gelombang laut umumnya mempunyai frekuensi yang relatif sangat rendah dibandingkan dengan frekuensi natural sistem. Gelombang dapat menjadi eksitasi yang berbahaya jika pada saat terjadinya *slamming*. Namun demikian fenomena *slamming* adalah masalah transient, oleh karena itu tidak relevan dengan permasalahan yang sedang dianalisa.

2. Mesin Induk (*Main Engine*)

Resonansi yang terjadi kendati dipengaruhi oleh mesin diesel lebih ke getaran torsional dan lateral.

3. *Propeller*

Jika dibandingkan dengan gelombang laut, *propeller* dan mesin induk, khususnya pada mesin induk yang memiliki *RPM* rendah hingga menengah memiliki frekuensi eksitasi disekitar nilai frekuensi natural. Namun pada getaran longitudinal, *propeller* hampir selalu menjadi penyebab utama dari getaran longitudinal sistem propulsi.

Untuk *propeller* yang memiliki “N” daun maka untuk setiap putaran akan terjadi “N” kali kenaikan gaya dorong, karena sebanyak itulah daun baling - baling akan melewati daerah dengan *wake* tinggi tersebut. Dari sini dapat didefinisikan bahwasannya nilai besaran dari frekuensi ekstiasi yang disebut *blade rate frequency* akibat pengaruh jumlah daun tersebut melalui persamaan (2.4):

$$\omega = 2\pi \frac{RPM}{60} N \quad (2.4)$$

Dimana:

RPM : RPM *Propeller*

N : Jumlah daun baling-baling

ω : Frekuensi Eksitasi (*rad/s*)

Resonansi akan terjadi pada sistem apabila frekuensi eksitasi sama dengan frekuensi natural.

Sistem propulsi mempunyai gaya eksitasi atau yang biasa disebut *alternating thrust*. Hal ini disebabkan karena osilasi gaya dorong. Gaya eksitasi merupakan penyebab getaran. Adapun perumusan dari gaya eksitasi dapat dijabarkan pada persamaan 2.5:

$$f(t) = F \cos(\omega t - \beta) \quad (2.5)$$

Dimana:

$f(t)$: Gaya Eksitasi (*kN*)

F : Amplitudo Eksitasi *Propeller* (*kN*)

ωt : *blade rate frequency*

β : Sudut Fase (0-15%)

Gaya eksitasi adalah *thrust* yang berubah dengan berubahnya waktu, berisolasi dengan didekati oleh fungsi harmonik, sedangkan T_0 disebut *steady thrust* yaitu harga *thrust* yang mendorong kapal. Dalam desain baling-baling *propeller*, T_0 ini yang digunakan sebagai referensi.

Besarnya amplitudo eksitasi (F) bisa ditulis sebagai prosentase dari besarnya *steady thrust* (T_O), dirumuskan dalam persamaan 2.6:

$$T_O = T_{OR} \left[\frac{RPM}{RPM_R} \right]^2 \quad (2.6)$$

Dimana:

T_O : *Steady Thrust* (kN)

T_{OR} : *Steady Thrust* maksimum pada kecepatan penuh.
(kN)

RPM : RPM *Propeller* pada kecepatan operasi.

ROM_R : RPM *Propeller* pada kecepatan maksimum.

Dengan demikian besarnya amplitudo eksitasi (F) untuk RPM tertentu dapat ditentukan dengan persamaan 2.7:

$$F = \beta \times T_{OR} \left[\frac{\omega}{\omega_{max}} \right]^2$$

atau

(2.7)

$$F(\omega) = \beta \times T_{OR} \left[\frac{\omega}{\omega_{max}} \right]^2$$

Sedangkan untuk amplitudo eksitasi pada getaran penuh, dapat dirumuskan pada persamaan 2.8:

$$F = \beta \times T_O \quad (2.8)$$

Besarnya amplitudo eksitasi ditulis sebagai prosentase dari besarnya *thrust* dengan koefisien β . Semakin kecil nilai β maka semakin kecil pula eksitasi yang terjadi. Oleh karena itu upaya untuk mengurangi getaran juga harus dilaksanakan pada sumber getaran disamping dari sistem itu sendiri. Besarnya sudut fasa (β) berkisar sebesar 0 – 15% tergantung dari bentuk bentuk dari buritan (*stern*) dan juga tergantung pada perencanaan *propeller*.

Ada beberapa cara yang dapat dilakukan untuk memperkecil sudut fasa (β):

1. *Skew*

Skew adalah sebuah bentuk daun *propeller* yang menyimpang dari bentuk daun *propeller* konvensional dengan memberi sudut tertentu. Dengan bentuk daun *propeller* yang seperti itu maka masukkan daun *propeller* pada daerah *wake* menyesuaikan dengan distribusi *wake* yang tidak seragam.

2. *Clearance*

Pada umumnya semakin besar nilai dari clearance maka distribusi *wake* akan semakin mendekati bentuk yang konvensional atau seragam. Dalam praktik besar clearance diambil berkisar 20%. Selain itu ada cara lain untuk memperbesar clearance yaitu dengan memasang baling-baling menggantung sedikit ke belakang.

Besarnya amplitudo getaran pada sistem dapat dirumuskan pada persamaan 2.9:

$$X = \frac{F/K}{\sqrt{\left[1 - \left(\frac{\omega}{\omega_n}\right)^2 + \left(2\zeta\frac{\omega}{\omega_n}\right)^2\right]}} \quad (2.9)$$

Dimana:

$$\begin{aligned}
 F &: \text{Amplitudo Eksitasi (kN)} \\
 k &: \text{Kekakuan Pegas (N/m)} \\
 \omega &: \text{Frekuensi Eksitasi (rad/s)} \\
 \omega_n &: \text{Frekuensi Natural (rad/s)} \\
 \zeta &: \text{Koefesien Redaman} \\
 &: \frac{c}{2m\omega_n}
 \end{aligned}$$

Untuk menentukan faktor redaman , dalam hal ini terdapat beberapa sumber redaman yang dapat mempengaruhi getaran longitudinal. Koefesien redaman (C) cenderung bertambah sesuai dengan banyaknya daun *propeller* dan dinyatakan bahwa besarnya koefesien redaman adalah sama dengan 39 lb sekon per inchi per foot dari piringan baling-baling *propeller* yang dapat dinyatakan dalam persamaan 2.10:

$$C = 39 \times \text{jari} - \text{jari propeller} \quad (2.10)$$

Pada standar untuk getaran longitudinal, ABS standar mengatur untuk kapal dengan menggunakan *twin screw* bahwa getaran longitudinal sistem propulsi dianggap berlebihan bila amplitudo eksitasi (F) lebih besar dari $0,022T_o$ untuk kapal dengan *propeller* 4 daun, $0,017T_o$ untuk kapal dengan *propeller* 5 daun dan $0,015T_o$ untuk kapal dengan *propeller* 6 daun.

Besarnya amplitudo eksitasi pada posisi terjepit sama dengan besarnya amplitudo eksitasi pada poros yaitu:

$$f_x(t) = K\theta(t)$$

Dimana :

$$\theta(t) = X \cos(\omega t - \beta)$$

$$X = \frac{F_s / K}{\sqrt{\left[1 - \left(\frac{\omega}{\omega_n}\right)^2\right]^2 + \left(2\zeta \frac{\omega}{\omega_n}\right)^2}}$$

Sehingga:

$$f_x = F_x \cos(\omega t - \beta)$$

Dimana :

$$F_x = \frac{F_s}{\sqrt{\left[1 - \left(\frac{\omega}{\omega_n}\right)^2\right]^2 + \left(2\zeta \frac{\omega}{\omega_n}\right)^2}}$$

Dimana :

$$F_s = \beta \times T_o$$

To adalah *steady* torsi pada frekuensi β dan ω adalah konstan. Sehingga jika harga tersebut dimasukkan, maka didapatkan persamaan 2.11

$$F_x = \frac{\beta \times T_o}{\sqrt{\left[1 - \left(\frac{\omega}{\omega_n}\right)^2\right]^2 + \left(2\zeta \frac{\omega}{\omega_n}\right)^2}} \quad (2.11)$$

2.4. GETARAN TORSIONAL PADA SISTEM PROPULSI

Getaran torsional adalah getaran sudut periodik poros elastis dengan rotor bulat yang dikaitkan kepadanya. Pada sistem propulsi getaran yang terjadi disebabkan bekerjanya eksitasi torsi.

Pada *propeller* akan bekerja enam komponen gaya atau momen osilasi (*unsteady force* / momen) yaitu tiga komponen gaya dan tiga komponen momen. Gaya dan momen tersebut terjadi karena *propeller* berputar pada daerah *wake* yang tidak seragam. Gaya atau komponen ini bekerja pada atau terhadap *hub*.

Keenam gaya atau momen tersebut bekerja serentak yang diasumsikan sebagai fungsi sinusoidal dengan frekuensi sebesar *blade rate frequency*, yaitu:

$$\omega = 2\pi \frac{RPM}{60} N \quad (2.12)$$

Dimana:

RMS : RPM *propeller*

N : Jumlah daun *propeller*

ω : Frekuensi Eksitasi (*rad/s*)

Model untuk getaran torsional sistem propulsi dapat didekati dengan sistem satu derajat kebebasan. Berikut adalah model dengan satu massa berikut:

Inersia massa (J) adalah digumpalkan pada posisi *propeller*, pegasnya adalah pegas torsional (K). Sedangkan redaman torsional (C) yang mencakup redaman hidrodinamis pada *propeller*. Getaran sistem ini adalah perpindahan sudut (θ) dengan satuan radian.

$$\theta(t) = X \cos(\omega t - \alpha)$$

Dimana besarnya X dapat dicari dari persamaan 2.13:

$$X = \frac{M/K}{\sqrt{\left[1 - \left(\frac{\omega}{\omega_n}\right)^2\right]^2 + \left(2\zeta\frac{\omega}{\omega_n}\right)^2}} \quad (2.13)$$

Dimana:

M : $\beta \times Q_o$

K : Kekakuan pegas (N/m)

C : Koefesien redaman.

ζ : Koefesien Redaman

$$: \frac{C}{2J\omega_n}$$

ω : Frekuensi Eksitasi (rad/s)

ω_n : Frekuensi Natural (rad/s)

$$: \frac{1}{2\omega} \sqrt{\frac{K}{J}}$$

J : momen inersia massa

Untuk nilai K dapat dicari dengan menggunakan perumusan sebagai berikut:

$$K = \frac{G \times J_a}{l} \quad (2.14)$$

Dimana:

G : Modulus geser (N/m^2)

J_a : Momen inersia luas

$$: \frac{\pi r^4}{2}$$

l : panjang poros (m)

Untuk nilai dari momen inersia massa (J) dapat dicari dengan cara sebagai berikut:

Momen inersia massa dari sistem ini terdiri atas tiga komponen, yaitu:

1. Momen inersia massa dari *propeller* (J_{Prop})
2. Momen inersia massa akibat berputarnya *propeller* di dalam air. Yaitu tambahan massa air yang seolah-olah ikut berputar dengan *propeller*, biasanya diambil sebesar 25% dari nilai momen inersia *propeller* (J_{Prop})
3. Sebagian momen inersia massa poros. Model dengan satu massa yang digunakan berasumsi bahwa pegas tidak mempunyai massa, padahal sebenarnya pegas juga tidak memiliki massa. Dalam hal ini adalah sebagian massa *propeller*. Dapat ditunjukkan bahwa frekuensi natural batang bulat seragam akan sama dengan momen inersia dari 1/3 massa tersebut yang diletakkan pada ujungnya, dengan asumsi pegas tanpa berat.

Dengan demikian maka momen inersia massa total dapat dirumuskan pada persamaan 2.15:

$$J = 1,25 J_{Propeller} + \frac{1}{3} J_{Propeller} \quad (2.15)$$

Dimana:

$$J_{Prop} : 0,25 R^2 \times M_{Prop}$$

$$J_{Poros} : J_a \times l$$

Besarnya torsi osilasi pada posisi terjepit sama dengan besarnya torsi osilasi pada poros yaitu:

$$m_x(t) = K \theta(t)$$

Dimana:

$$\theta(t) = X \cos(\omega t - \alpha)$$

$$X = \frac{M_s / K}{\sqrt{\left[1 - \left(\frac{\omega}{\omega_n}\right)^2\right]^2 + \left(2\zeta \frac{\omega}{\omega_n}\right)^2}}$$

Sehingga:

$$m_x = M_x \cos(\omega t - \alpha)$$

Dimana :

$$M_x = \frac{M_s}{\sqrt{\left[1 - \left(\frac{\omega}{\omega_n}\right)^2\right]^2 + \left(2\zeta\frac{\omega}{\omega_n}\right)^2}}$$

Dimana :

$$M_s = \beta \times Q_o$$

Q_o adalah *steady* torsi pada frekuensi β dan ω adalah konstan. Sehingga jika harga tersebut dimasukkan, maka didapatkan persamaan 2.16

$$\frac{M_x}{Q_o} = \frac{\beta}{\sqrt{\left[1 - \left(\frac{\omega}{\omega_n}\right)^2\right]^2 + \left(2\zeta\frac{\omega}{\omega_n}\right)^2}} \quad (2.16)$$

2.5 TEGANGAN GETARAN TORSIONAL

Tegangan pada getaran torsional adalah tegangan yang mampu diterima oleh material yang diakibatkan oleh getaran torsional. Pada BKI diatur mengenai batas maksimum sebuah material poros dalam merima tegangan yang diakibatkan oleh getaran torsional.

Pada BKI dibagi menjadi dua kondisi mengenai hal tersebut, yaitu pada kondisi operasi secara terus menerus (τ_1) (kontinyu) dan pada kondisi sementara (τ_2). Selain itu BKI juga membaginya kembali berdsarkan bentuk poros, yaitu yang

menggunakan *propeller shaft* dan *intermediate shaft*. Dimana *propeller shaft* memiliki nilai $C_K = 0,55$ atau $C_K = 0,45$ dan untuk *intermediate shaft* memiliki nilai $C_K = 1,0$ atau $C_K = 0,8$.

Berikut persamaan untuk menentukan batas tegangan yang diterima material poros berdasarkan standar BKI:
Persamaan untuk menghitung tegangan pada poros pada kondisi operasi secara terus menerus (τ_1):

Untuk *speed ratio* $\lambda < 0,9$ (2.17)

$$\tau_1 = \pm C_w \times C_k \times C_d \times (3 - 2\lambda^2) \quad (2.17)$$

Untuk *speed ratio* $0,9 \leq \lambda \leq 1,05$ (2.18)

$$\tau_1 = \pm C_w \times C_k \times C_d \times 1,38 \quad (2.18)$$

Selain persamaan diatas 2.17 dan 2.18 adalah persamaan alternatif dan tergantung pada bahan dan desain poros, berikut persamaan 2.19 yang dapat digunakan sebagai gantinya:

$$\tau_1 = \pm 1,7 \times 6,0 \times \frac{\tau_1}{\sqrt{C_k \times C_w}} \quad (2.19)$$

Sedangkan untuk menghitung tegangan pada poros pada kondisi sementara (τ_2) dapat menggunakan persamaan 2.20 sebagai berikut:

$$\tau_2 = \pm 1,7 \times \frac{\tau_1}{\sqrt{C_k}} \quad (2.19)$$

Dimana:

C_w : Faktor Material
 $: (R_m + 160) / 18$

C_k : Koefesien faktor dari jenis poros
 C_d : Faktor Ukuran
 $: 0,35 + 0,93d^{-0,2}$

λ : rasio kecepatan
 $: n/no$

n : Kecepatan rata-rata (knot)
 no : Kecepatan maksimum (knot)
 d : diameter poros (mm)

Untuk semua persamaan (2.17), (2.18), (2.19) dan (2.20) nilai dari *tensile strength* tidak boleh melebihi dari batas yang telah ditentukan sebagai berikut:

R_m : 600 N/mm^2

✓ Untuk *direct coupled plant* menggunakan material pada umumnya nilai dari *tensile strength* harus $R_m \geq 500 \text{ N/mm}^2$. Sedangkan untuk *geared plants* atau lainnya dengan nilai getaran torsional yang rendah, material poros harus memiliki nilai *tensile strength* sebesar $R_m \geq 400 \text{ N/mm}^2$

✓ Untuk *propeller shaft* pada umumnya

- ✓ Untuk semua *intermediate shaft* yang terbuat dari *low alloy carbon* atau *carbon manganese steel*.

R_m : 800 N/mm^2

- ✓ Untuk semua poros kecuali *propeller shaft* yang terbuat dari *high alloy steels*. Persamaan 2.19 harus digunakan.

2.6 PENGUKURAN GETARAN

Sebelum dilakukan pengukuran getaran terlebih dahulu ditentukan titik-titik yang akan dilakukan sebagai objek pengukuran. Dalam proses pengukuran getaran ada beberapa contoh alat yang dapat digunakan, diantaranya:

1. Accelerometer.
Alat ini akan memproduksi semacam sinyal, ukuran sinyal tersebut sangatlah proposional untuk diaplikasikan didalam mengukur perlajuan daripada getaran.
2. Frequency Analyzer
Alat ini akan menghasilkan distribusi daripada perlajuan getaran frekuensi yang berbeda.
3. Frequency Weighting Network.
Alat ini menirukan sensitif pada manusia terhadap getaran pada frekuensi yang berbeda. Dengan menggunakan alat ini akan dihasilkan data dalam bentuk satuan m/s^2

2.7 STANDAR INTERNASIONAL DAN PERATURAN PEMERINTAH

Standar International ini digunakan untuk membandingkan hasil pengukuran dan perhitungan apakah sesuai standar yang diacu atau tidak. Berikut standar yang diacu dalam komparasi hasil perhitungan dan pengukuran.

2.7.1 ABS (American Bureau of Shipping)

ABS mengatur batasan dari nilai getaran longitudinal sebagai berikut:

“Amplitudo eksitasi pada getaran torsional pada kapal yang menggunakan *twin screw* rata-rata adalah 0,022To untuk *propeller* dengan jumlah daun 4, 0,017To untuk *propeller* dengan jumlah daun 5 dan 0,015To untuk *propeller* dengan jumlah daun 6”

Sedangkan untuk getaran torsional, ABS menyatakan bahwa:

“Torsi getaran atau torsi yang berosilasi pada kapal yang menggunakan *twin screw* sebesar 0,016Qo pada 4 baling-baling, 0,0014Qo pada 5 baling-baling dan 0,0010Qo pada 6 baling-baling”

Pada ABS juga mengatur mengenai nilai ambang batas getaran dari komponen mesin propulsi. berikut nilai ambang batas mesin propulsi yang diatur pada ABS:

Tabel 2.1 Nilai Ambang Batas Getaran pada Mesin Propulsi

<i>Propulsion Machinery</i>	<i>Limits (RMS)</i>
<i>Thrust bearing and bull gear hub</i>	5 mm/s
Other propulsi machinery component	13 mm/s
Stern tube and line shaft bearing	7 mm/s
Diesel engine at bearing	13 mm/s
Slow & medium speed diesel engine (over 1000 hp)	18 mm/s
High speed diesel engine (less 1000 hp)	13 mm/s

Selanjutnya ABS juga mengatur getaran terhadap tingkat kenyamanan bagi ABK:

Tabel 2.2 Nilai ambang batas getaran terhadap ABK Kapal

ABS Optional Notation	Freq. Range	Maximum Level
HAB/COMF	0,5 – 80 Hz	0,4 m/s ²
HAB+/COMF+	0,5 – 80 Hz	0,315 m/s ²

2.7.2 ISO 2631

Aturan ISO terhadap tingkat getaran lebih menekankan kepada tingkat kenyamanan dan keamanan bagi pekerja. Karena dampak getaran terhadap manusia secara kontinyu akan menyebabkan kelelahan bagi pekerja, sehingga dapat menurunkan tingkat produktivitas kerja. Berikut nilai ambang batas getaran yang diizinkan berdasarkan ISO 2631:

Tabel 2.3 Nilai Ambang Batas Getaran Terhadap Tubuh bagi Pekerja

<i>Scale</i>	Mean Magnitude (m/s^2)
Extremely Uncomfortable	<i>Greaten tahn 2</i>
Very Uncomfortable	1,25 – 2
Uncomfortable	0,8 – 1,6
Fairly Uncomfortable	0,5 – 1
A Little Comfortable	0,315 – 0,63
Comfortable	Less than 0,315

2.7.3 Keputusan Menteri Tenaga Kerja RI No.51 Tahun 1999

Berdasarkan keputusan menteri tersebut tentang nilai ambang batas faktor fisika ditempat kerja yang memuat tentang nilai ambang batas getaran sebagai berikut:

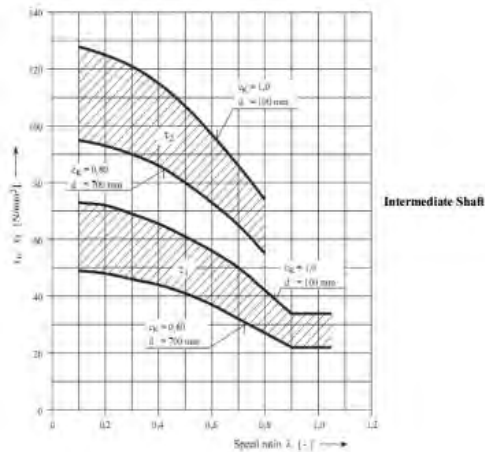
Tabel 2.4 Nilai Ambang Batas Getaran Menurut Keputusan Menteri Tenaga Kerja No.51 Tahun 1999

Waktu	Magnitude (m/s^2)
4 jam dan kurang dari 8 jam	4 m/s^2
2 jam dan kurang dari 4 jam	6 m/s^2
1 jam dan kurang dari 2 jam	8 m/s^2
Kurang dari 1 jam	12 m/s^2

2.7.4 BKI (Biro Klasifikasi Indonesia)

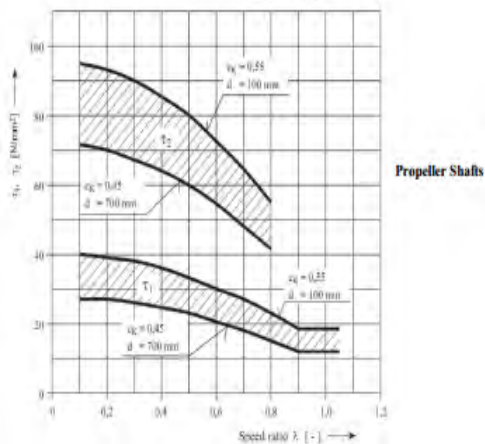
Dalam BKI diatur mengenai tingkat tegangan pada poros akibat dari getaran torsional. Dimana pada BKI diatur dalam dua kategori, yaitu berdasarkan poros yang digunakan:

1. Tingkat tegangan pada *Intermediate shaft*



Gambar 2.3: Batas tegangan yang diizinkan pada intermediate shaft.

2. Tingkat tegangan pada *Propeller shaft*.



Gambar 2.4: Batas tegangan yang diizinkan pada propeller shaft.

BAB III METODOLOGI

3.1 UMUM

Metodologi merupakan sebuah kerangka acuan yang digunakan dalam menjawab permasalahan yang diangkat dalam suatu tugas akhir. Metodologi ini meliputi seluruh tindakan atau langkah-langkah yang akan dilakukan dalam proses penulisan tugas akhir tersebut.

3.2 STUDI LITERATUR

Studi literatur ini dilakukan untuk mempeleajari teori-teori yang dapat menunjang dalam menyelesaikan masalah yang diangkat dalam tugas akhir ini. Teori-teori yang berhubungan dengan analisa getaran, getaran longitunal, getaran torsional dan standar acuan apa saja yang akan digunakan sebagai pembanding. Studi literatur yang digunakan dalam proses pengerjaan tugas ini diperoleh dari, buka tugas akhir, paper, standar international serta internet yang berhubungan dengan analisa getaran pada ruang kamar mesin kapal.

3.3 PENGUMPULAN DATA

Proses pengumpulan data ini dilakukan untuk mencatat data-data yang dibutuhkan dalam proses pengerjaan serta menentukan titik-titik pengukuran yang akan dilakukan selanjutnya. Proses pengumpulan serta objek yang akan dianalisa adalah kapal ro-ro, KMP. DHARMA RUCITRA, milik perusahaan pelayaran Dharma Lautan Utama. Kapal ro-ro ini melayani penyebrangan Ketapang – Gilimanuk (PP).



Gambar 3.1 KMP. DHARMA RUCITRA

Tabel 3.1 Indentitas Kapal

KMP. DHARMA RUCITRA	
Pemilik	PT. Dharma Lautan Utama
Rute Pelayaran	Ketapang – Gilimanuk
Tempat Pembuatan	Jepang
Galangan Pembangunan	Hitachi Shipbuilding CO, Ltd.
Tahun Pembuatan	1984
Bahan	Baja
Tipe Kapal	Ro – Ro
Klasifikasi	BKI

Tabel 3.2 Ukuran Utama Kapal

Ukuran Utama Kapal		
LOA	48	Meter
LWL	44,07	Meter
Lebar	12,40	Meter
Tinggi	3,4	Meter
Draft	2,3	Meter
GT	196	Ton

Tabel 3.3 Data Kapasitas Muat

Kapasitas Muat	
Jumlah Penumpang	247 Orang
Jumlah Kendaraan	25 Campuran
Jumlah Crew	25 orang

*Gambar 3.2 Mesin Induk KMP. DHARMA RUCITRA*

Tabel 3.4 Data Utama Mesin Induk

Mesin Induk	
Merk	Hanshin
Tipe	Z6E MRS
Tenaga Kuda	2 x 450 Hp
Jumlah Mesin	2 Buah
Kecepatan Maksimum	10 Knot
Tahun Pembuatan	1964
RPM	400

3.4 PERHITUNGAN GETARAN

Perhitungan getaran dilakukan pada getaran longitudinal dan getaran torsional yang terjadi pada sistem propulsi kapal, KMP. DHARMA RUCITRA. Perhitungan dilakukan berdasarkan data-data yang terdapat pada kapal. Berikut langkah-langkah dalam proses perhitungan getaran secara manual:

Getarang Longitudinal

- Perhitungan Frekuensi Eksitasi
- Perhitungan Frekuensi Natural
- Perhitungan Tahanan Kapal
- Perhitungan Steady Thrust
- Perhitungan Amplitudo Eksitasi getaran pada kecepatan penuh
- Perhitungan Amplitudo getaran pada sistem

Getaran Torsional

- Perhitungan frekuensi eksitasi
- Perhitungan frekuensi natural
- Perhitungan orsilasi torsi

3.5 PERHITUNGAN TEGANGAN GETARAN TORSIONAL

Perhitungan *Tensile Stress* dilakukan pada shaft, akibat dampak dari getaran torsional pada sistem propulsi. perhitungan ini dilakukan untuk mengetahui kekuatan dari shaft tersebut apakah sesuai standar yang telah ditentukan atau tidak. Perhitungan ini sendiri berdasarkan data-data kapal yang terdapat pada kapal, KMP. DHARMA RUCITRA.

3.6 PENGUKURAN GETARAN

Proses pengukuran getaran dilakukan secara langsung dengan meninjau langsung pada ruang kamar mesin KMP. DHARMA RUCITRA. Proses Pengukuran dilakukan beberapa kali untuk mencegah terjadinya anomali pada data hasil pengukuran.

Alat yang digunakan pada pengukuran getaran yaitu berupa vibration meter. Vibration meter dengan display digital. Vibration meter dengan merk Lutron, model VB-8200. Berikut spesifikasi dari alat pengukur getaran yang digunakan.



Gambar 3.3 Vibration Meter Lutron VB-8200

Tabel 3.5 Spesifikasi Alat Pengukur Getaran

Merk	Lutron
Model	VB-8200
Display	61 mm x 34 mm supper large LCD dispaly. 15 mm (0,6") digit size.
Measurement	Velocity Acceleration RMS Value, Peak Value, Data Hold, Max & Min, value.
Range	Velocity: 200 mm/s: 0,5 to 199,9 mm/s
	Acceleration: 200 m/s ² : 0,5 to 199,9 m/s ²
Frequency Range	10 hz to 1 KHz
Accuracy	± (5% +2d) reading, 160 Hz, 80 hz
Calibration Point	Velocity: 50 mm/s (160 Hz)
	Acceleration: 50 m/s ² (160 hz)
Circuit	Exclusive mircrocomputer circuit.
Data Hold	Freeze the desired reading.
Peak Measurement	To measure the peak value.
Memory	Maximum and Minimum value.
Sampling Time	Approx. 1 Second
Data Output	RS 232 Serial output, isolate.
Operating Temperature	0 °C to 50 °C
Operating Humidity	Less than 80% RH

3.6.1 TATA CARA PEMAKAIAN *VIBRATION METER*

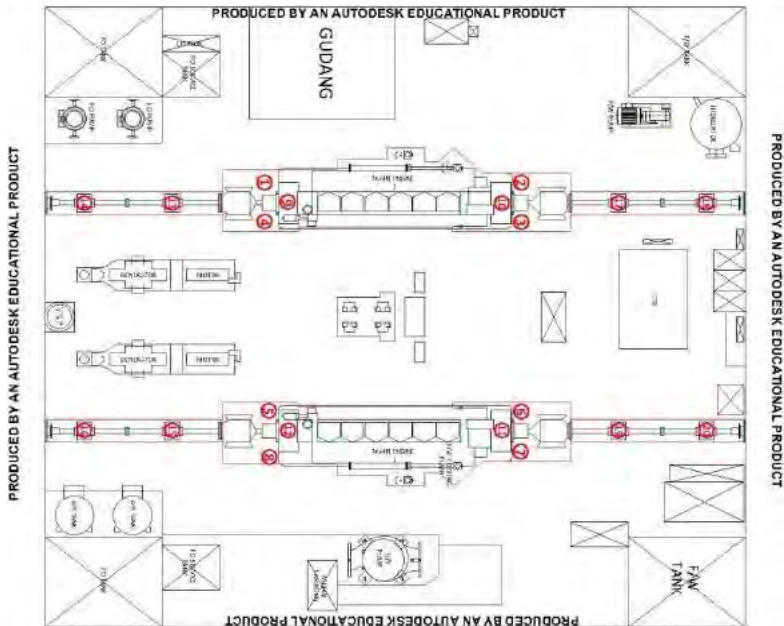
Berikut tata cara dalam menggunakan alat pengukur getaran:

1. Sambungkan kabel BNC yang telah tersedia pada *socket* yang terdapat pada alat pengukur getaran.

2. Pilihlah jenis mode hasil pengukuran yang akan diinginkan. Ada dua jenis mode hasil pengukuran yang dapat dilakukan yaitu, pengukuran *Acceleration* dan *Velocity*. Pilihlah salah satu mode hasil pengukuran dengan menggeser panel, “ACC” untuk mode pengukuran *Acceleration* dan “VEL” untuk mode pengukuran *Velocit*.
3. Pilih jenis pengukuran apa yang akan digunakan. Ada dua jenis pengukuranm yaitu pengukuran RMS dan PEAK. Pilihlah salah satu pengukuran dengan menggeser ke arah panel yang diinginkan.
4. Pijahlah tombol *Power* satu kali (berwarna merah) untuk menyalakan alat pengukur getaran.
5. Tempelkan ujung kabel BNC yang dilengkapi dengan sensor dan magnet pada permukaan yang akan diukur getannya. (*jika permukaan material yang diukur bukanlah material ferromagnetic maka, tekanlah ujung kabel BNC menggunakan tangan*)
6. Pada saat proses pengamatan, tunggulah hingga display pengukuran menunjukkan angka yang konstan atau stabil. Setelah itu tekanlah tombol “Hold” satu kali untuk mengunci pada display pada nilai tersebut.

3.7 PENENTUAN TITIK PENGUKURAN

Sebelum melakukan proses pengukuran getaran, terlebih dahulu menentukan titik-titik yang akan dilakukan pengukuran. Penentuan titik pengukuran pada kapal KMP. DHARMA RUCITRA berdasarkan pada daerah sekitar sistem propulsi, yaitu pada pondasi mesin induk, *clutch*, dan *plummer block*. Daerah tersebut dipilih karena daerah tersebut mengalami kontak langsung dengan getaran longitudinal dan getaran torsional.



Gambar 3.4 Titik – Titik Pengukuran Getaran

3.8 PENGECEKKAN STANDART DAN PERATURAN PEMERINTAH

Standard yang digunakan sebagai acuan dan batas toleransi pada pengukuran dan perhitungan getaran serta *tensile stress* yang telah dilakukan sebelumnya. Monitoring kondisi getaran yang berlebih dalam prosedur teknis dalam analisa getaran, sehingga dapat memberikan petunjuk umum sebagai batas-batasan dalam proses melakukan pengukuran getaran untuk mengontrol kondisi yang terjadi. Sehingga pada ABS (*American Bureau Shipping*), ISO (*Internation Standard Organization*) dan Keputusan Menteri Ketenagaan Kerjaan memberikan batasan toleransi getaran yang diizinkan.

3.9 Analisa Data

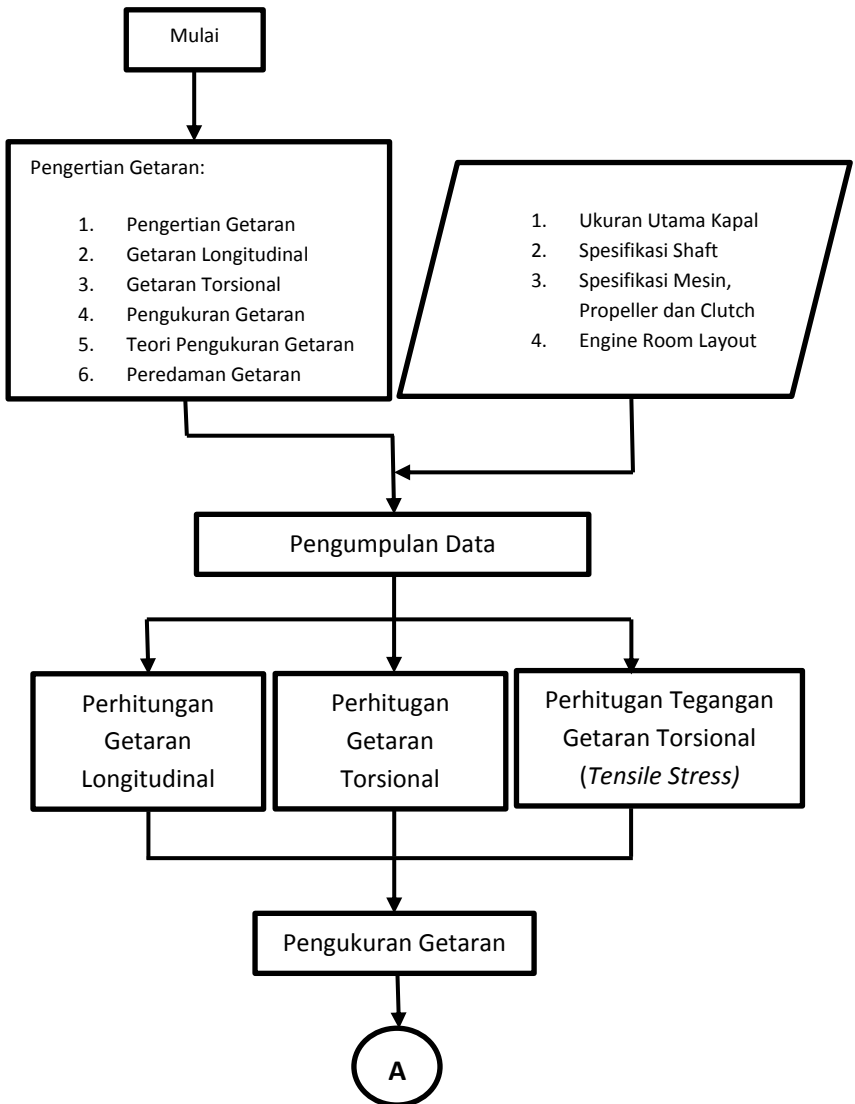
Setelah pengumpulan data dan pengukuran getaran telah dilakukan, maka hal-hal yang akan dilakukan adalah sebagai berikut:

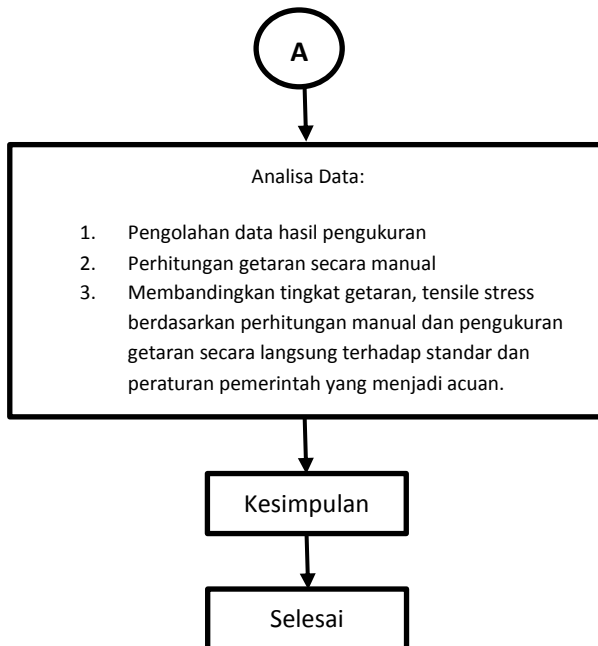
1. Pengolahan hasil data pengukuran
2. Perhitungan getaran secara manual
3. Membandingkan tingkat getaran, *tensile stress* berdasarkan perhitungan manual dan pengukuran secara langsung terhadap standar yang menjadi acuan.

3.10 Kesimpulan dan Saran

Hasil dari analisa data tersebut, selanjutnya akan dibuat suatu laporan penelitian yang berupa penulisan ilmiah dan dipublikasikan atau dipresentasikan pada sidang tugas akhir. Dan diusahakan hasil dari tugas akhir ini dapat digunakan sebagai acuan dan pertimbangan bagi perusahaan pelayaran yang kapalnya digunakan sebagai objek penelitian (KMP. DHARMA RUCITRA) agar menjadi lebih baik dan nyaman sesuai dengan standar yang berlaku.

3.11 Flow Chart Metodologi Penelitian





“Halaman ini sengaja dikosongkan”

BAB IV

ANALISA DATA DAN PEMBAHASAN

4.1 ANALISA GETARAN

Dalam menganalisa getaran pada kamar mesin dapat dilakukan dua cara yaitu dengan dengan cara perhitungan berdasarkan desain atau kondisi menurut data tertulis dan mengukur langsung pada kamar mesin yang bersangkutan, pada analisa getaran ini dilakukan pada kapal KMP. Dharma Rucitra. Kapal RO-RO penyeberangan Ketapang – Gilimanuk, milik PT. Dharma Lautan Utama. Dalam menganalisa getaran pada kamar mesin kita harus mengetahui terlebih dahulu sumber getaran yang terjadi pada tempat tersebut. Sumber getaran biasa terjadi pada benda atau komponen yang berputar, pada kamar mesin ini sumber getaran terbesar terjadi pada sistem propulsi. dimana sumber getaran tersebut diakibatkan oleh poros, mesin induk dan *propeller*.

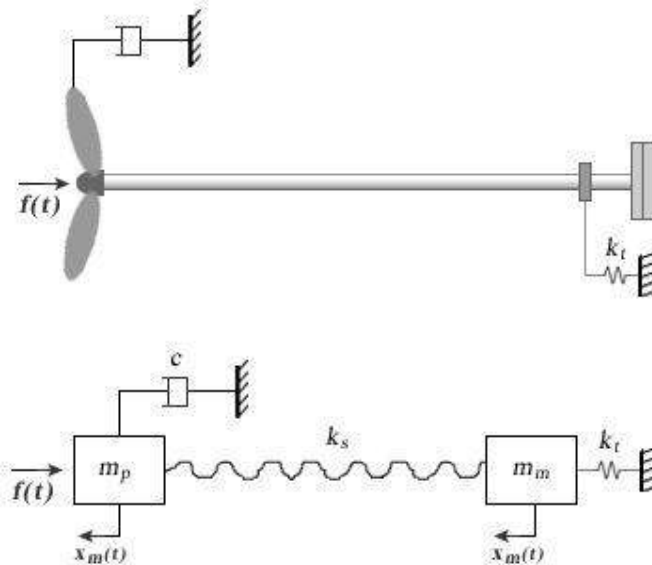
Dalam tugas akhir ini analisa getaran dilakukan menggunakan kedua cara tersebut dimana menggunakan perhitungan berdasarkan desain serta pengukuran getaran secara langsung pada kamar mesin kapal. Dan nantinya hasil dari dari kedua pengukuran dibandingkan dengan standart dan aturan yang digunakan sebagai acuan.

4.2 PERHITUNGAN GETARAN

Perhitungan getaran secara manual KMP. Dharma Rucitra dilakukan pada dua jenis getaran yang terjadi pada sistem propulsi, yaitu getaran longitudinal sistem propulsi dan getaran torsional sistem propulsi. Hal ini dilakukan untuk mendapatkan nilai tingkat getaran pada sistem propulsi pada saat kondisi sekarang.

4.2.1 GETARAN LONGITUDINAL SISTEM PROPULSI

Getaran longitudinal sistem propulsi adalah getaran yang arah kordinat gerakanya sejajar dengan poros *propeller*. Getaran longitudinal ini timbul akibat dari gaya dorong yang disebabkan oleh baling-baling dan ditahan oleh thrust block. Oleh sebab itu gaya aksial yang ditimbulkan tersebut dapat menyebabkan *thrust block* dan pondasi kamar mesin mengalami pergeseran secara longitudinal. Jika sistem propulsi ini dianggap sebagai satuan masa tegar, maka semua titik pada sistem propulsi akan bergetar dengan perpindahan aksial yang sama besar.



Gambar 4.1 Model Getaran Longitudinal Sistem Propulsi
(<http://ftk-its.info/elearn/long1.htm>)

Perhitungan getaran longitudinal pada kapal KMP. Dharma Rucitra ini dilakukan untuk mengetahui tingkat getaran pada kapal tersebut berdasarkan teori dan perhitungan manual. Berikut rincian dari perhitungan getaran longitudinal pada kapal KPM. Dharma Rucitra

A. Perhitungan Frekuensi Eksitasi

$$\omega = 2\pi \frac{RPM}{60} N \text{ (rad/s)}$$

Diketahui data sebagai berikut:

RPM Mesin Induk : 250

*Pada spesifikasi mesin induk, RPM yang tertera adalah 400 RPM. Namun, pada kondisi sesungguhnya, mesin induk sudah tidak mampu mencapai kondisi RPM tersebut.

Jumlah Daun *Propeller* : 4

Sehingga didapatkan nilai dari Frekuensi Eksitasi adalah:

$$\omega = 2 \times 3,14 \frac{250}{60} 4$$

$$\omega = 104,67 \text{ rad/s}$$

B. Perhitungan Frekuensi Natural

$$\omega_n = \frac{1}{2\pi} \sqrt{\frac{k}{M}} \text{ (rad/s)}$$

Dimana harus dicari terlebih dahulu nilai dari Kekakuan Pegas (K),

K = Kekakuan pegas (N/m)

$$K = \frac{E \times A}{l}$$

Diketahui:

$$E = 17553903,5 \text{ N/m}^2$$

$$A = 7,8877 \text{ m}^2$$

$$l = 0,25 \text{ m}$$

Sehingga didapat nilai K sebagai berikut,

$$K = \frac{17553903,5 \times 7,887}{0,25}$$

$$K = 553838294 \text{ N/m}$$

Diketahui massadari sistem propulsi,

$$m = 14000 \text{ Kg} = 137200 \text{ N}$$

Sehingga didapatkan nilai Frekuensi Natural (F_n),

$$\omega_n = \frac{1}{2 \times 3,14} \sqrt{\frac{553838294}{137200}} \text{ (rad/s)}$$

$$\omega_n = 99,75 \text{ rad/s}$$

C. Perhitungan *Steady Thrust* (T_o)

$$T_o = T_{or} \left[\frac{RPM}{RPMr} \right]^2$$

Untuk mendapatkan nilai dari *Steady Thrust* (T_o) terlebih dahulu menghitung dari tahanan kapal.

Diketahui data utama kapal KMP. Dharma Rucitra sebagai berikut,

$$L_{pp} = 48,6 \text{ m}$$

$$L_{wl} = 44,1 \text{ m}$$

$$B = 12,4 \text{ m}$$

$$T = 2,3 \text{ m}$$

$$D = 3,4 \text{ m}$$

$$CB = 0,6$$

$$CP = 0,61$$

$$V_s = 8 \text{ Knot} = 4,112 \text{ m/s}$$

1. Perhitungan *Volume Displacement*

$$V = Lwl \times B \times T \times CB_{wl}$$

$$V = 44,1 \times 12,4 \times 2,3 \times (48,6 \times 0,6 / 44,1)$$

$$V = 831,643 \text{ m}^3$$

2. Perhitungan *Displacement*

$$\Delta = V \times \rho$$

$$\rho = \text{masa jenis air laut} = 1,025 \text{ ton/m}^3$$

$$\Delta = 831,64 \times 1,025$$

$$\Delta = 852,434 \text{ ton}$$

3. Perhitungan *Froud Number*

$$F_n = \frac{v_s}{\sqrt{g \times lwl}}$$

$$F_n = \frac{4,112}{\sqrt{9,8 \times 44,1}}$$

$$F_n = 0,1978$$

4. Perhitungan *Raynold Number*

$$R_n = \frac{v_s \times lwl}{v_k}$$

$$R_n = \frac{4,112 \times 44,1}{1,188 \times 10^{-6}}$$

$$R_n = 152642424,2$$

5. Perhitungan Luas Permukaan Basah

$$S = 1,025 \times lpp \times (CB \times B \times 1,7 \times T)$$

$$S = 1,025 \times 48,6 \times (0,6 \times 12,4 \times 1,7 \times 2,3)$$

$$S = 565,4 \text{ m}^2$$

6. Perhitungan Koefesien Tahanan Gesek

$$C_f = \frac{0,075}{(\log_{10} R_n - 2)^2}$$

$$C_f = \frac{0,075}{(\log_{10} 152642424,2 - 2)^2}$$

$$C_f = 0,001961408$$

7. Perhitungan Koefesien Tahanan Residu

$$lwl/V^{1/3} = \frac{44,1}{(831,64)^{1/3}}$$

$$lwl/V^{1/3} = 4,6895$$

$lwl/V^{1/3}$	$10^3 Cr$
4,5	0,9
4,6895	$10^3 Cr$
5	0,85

Nilai Cr pada 4,5 dan 5 didapatkan dengan membaca grafik diagram guldamer.

Sehingga untuk mendapatkan nilai Cr pada nilai 4,6895 harus dilakukan interpolasi. Didapatkan nilai Cr pada 4,6895 adalah:

$$10^3 Cr = 0,715$$

$$Cr = 0,000715$$

8. Koreksi nilai Cr terhadap lebar kapal dengan draft kapal.

$$Cr = Cr + (0,16 \times (\frac{B}{T} - 2,5))$$

$$Cr = 0,000715 + (0,16 \times (\frac{12,4}{2,3} - 2,5))$$

$$Cr = 0,0011776$$

9. Koreksi Cr terhadap Anggota Badan Kapal.

Koreksi ini dilakukan akibat adanya bos *propeller*, sehingga nilai Cr dinaikkan berkisar 3%-5%. Dalam perhitungan ini nilai Cr diambil sebesar 4%. Sehingga didapatkan nilai Cr sebesar:

$$Cr = (1 + 4\%) \times Cr$$

$$Cr = (1 + 4\%) \times 0,0011776$$

$$Cr = 0,001225$$

10. Koefisien tahanan tambahan sebagai koreksi Cf

Dalam menentukan nilai Ca terdapat dua cara yaitu menggunakan L atau Displacement. Dalam perhitungan kali ini menggunakan Displacement sebagai cara menentukan nilai Ca .

Nilai ▼	$10^3 Ca$
1000 ton	0,6
10000 ton	0,4
100000 ton	0
1000000 ton	-0,6

Diketahui nilai dari displacement sebesar 852,434 ton. Sehingga jika kita merujuk pada tabel tersebut, didapatkan nilai dari Ca sebesar:

$$10^3 Cr = 0,6$$

$$Cr = 0,0006$$

11. Tahanan kemudi sebagai koreksi nilai Cr

$$10^3 cas = 0,04$$

$$cas = 0,0004$$

12. Tahanan udara sebagai koreksi nilai Cr

$$10^3 cas = 0,07$$

$$cas = 0,0007$$

13. Perhitungan Tahanan Total

$$Ct = Cf + Cr + Ca$$

$$Ct = Cf + (Cr + Caa + Cas) + Ca$$

$$Ct = 0,001961 + (0,001225 + 0,00007 + 0,00004) + 0,0006$$

$$Ct = 0,003896$$

$$Rt = Ct \times \frac{1}{2} \times \rho \times Vs^2 \times S$$

$$Rt = 0,003896 \times \frac{1}{2} \times 1,025 \times V(4,112)^2 \times 4969,2669$$

$$Rt = 19,0892 \text{ kN}$$

$$Rt(dinas) = (1 + 15\%) \times Rt$$

$$Rt(dinas) = (1 + 15\%) \times 19,0892$$

$$Rt(dinas) = 21,9526 \text{ kN}$$

14. Perhitungan Daya Efektif Kapal (EHP)

$$EHP = Rt(dinas) \times Vs$$

$$EHP = 21,9526 \times 4,112$$

$$EHP = 90,269 \text{ kW}$$

$$EHP = 90,269 \text{ kW}$$

15. Perhitungan Daya Tabung Poros *Propeller* (DHP)

$$EHP = \frac{DHP}{Pc}$$

Dimana nilai dari Pc didapatkan dari:

A. Efisiensi Lambung (w)

$$\eta_H = (1 - t) \times (1 - w)$$

Dimana w adalah *wake fraction* atau arus ikut, merupakan perbandingan antara kecepatan kapal dengan kecepatan air yang menuju ke *propeller*. Nilai dari *wake friction* pada C_b 0,6 pada kapal menggunakan *twin screw* sebesar:

$$w = 0,007$$

Principles of Naval Architecture Vol 2. Hal 158

Thrust Deduction Factor (t)

Nilai dari *thrust deduction factor* dapat didapatkan dengan menggunakan rumus:

$$t = k \times w$$

Dimana nilai K berkisar antara 0,7 – 0,9

Pada perhitungan kali ini diambil nilai K sebesar 0,8, sehingga didapat nilai *thrust deduction factor (t)* sebesar:

$$t = 0,8 \times 0,007$$

$$t = 0,0056$$

Sehingga didapatkan nilai dari efisiensi lambung η_H

$$\eta_H = (1 - 0,0056) \times (1 - 0,007)$$

$$\eta_H = 0,9874$$

16. Perhitungan Thrust (Tor)

$$Tor = \frac{Rt}{(1 - t)}$$

$$Tor = \frac{21,953}{(1 - 0,0056)}$$

$$T_{or} = 22,077 \text{ kN}$$

D. Perhitungan *Steady Thrust* (T_o)

$$T_o = T_{or} \left(\frac{RPM}{RPM_r} \right)^2$$

Diketahui Nilai dari:

RPM = 220 (Putaran *propeller* pada kondisi normal)

RPM_r = 250 (Putaran *propeller* pada kecepatan penuh)

T_{or} = 22,077 Kn (*thrust pada kecepatan penuh*)

Sehingga didapatkan nilai dari *steady thrust* (T_o) adalah:

$$T_o = 22,077 \left(\frac{220}{250} \right)^2$$

$$T_o = 17,096 \text{ kN}$$

E. Perhitungan Amplitudo Eksitasi (F)

$$F = \beta \times T_{or} \left(\frac{RPM}{RPM_r} \right)^2$$

β adalah persentase besarnya amplitudo eksitasi. Besarnya nilai β sendiri berkisar antara 0% -15%, tergantung dari permukaan buritan dan desain daun *propeller*.

Pada perhitungan ini diambil nilai dari β sebesar 7,5%. Sehingga didapatkan nilai dari amplitudo eksitasi sebesar:

$$F = 0,075 \times 17,096$$

$$F = 1,282 \text{ kN}$$

F. Perhitungan Amplitudo Eksitasi pada Poros (F_x)

$$F_x = \frac{\beta \times T_o}{\sqrt{\left[1 - \left(\frac{\omega}{\omega_n}\right)^2\right]^2 + \left[2\zeta \frac{\omega}{\omega_n}\right]^2}}$$

Dimana diketahui:

ζ = koefisien redaman.

$$\zeta = \frac{C}{2 \times m \times \omega_n}$$

C = Koefisien damping

$$C = 39 \times r_{propeller}$$

m = berat massa sistem (N)

Sehingga nilai dari koefisien redaman adalah:

$$\zeta = \frac{C}{2 \times m \times \omega_n}$$

Diketahui:

$$r_{propeller} = 750 \text{ mm} = 2,46 \text{ ft}$$

$$m = 137,2 \text{ kN}$$

$$\omega_n = 99,75$$

$$\zeta = \frac{39 \times 2,46}{2 \times 137200 \times 99,75}$$

$$\zeta = 3,5e - 6$$

Sehingga dapat diketahui nilai dari amplitudo getaran pada sistem

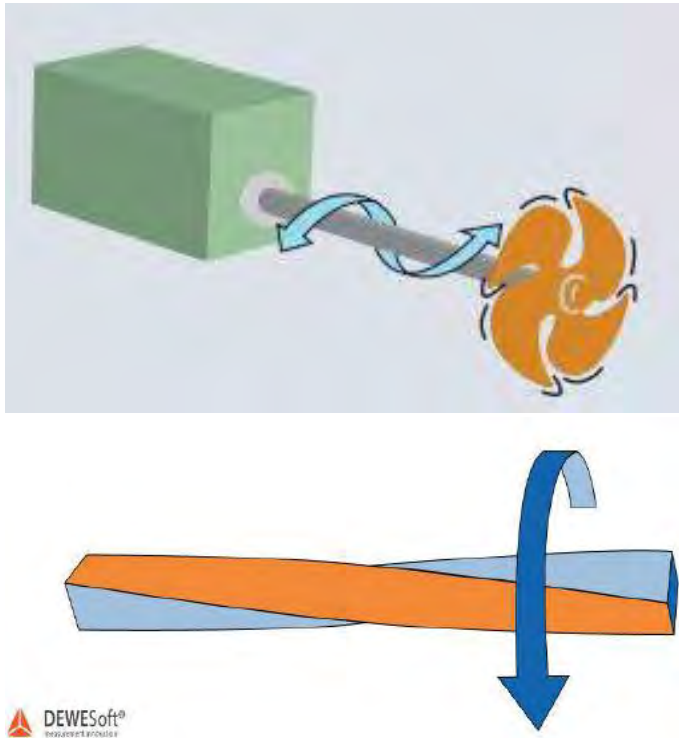
$$F_x = \frac{0,075 \times 17,096}{\sqrt{\left[1 - \left(\frac{104,67}{99,75}\right)^2\right]^2 + \left[2(3,5e - 6) \frac{104,67}{99,75}\right]^2}}$$

$$F_x = 0,217 \text{ kN}$$

4.2.2 GETARAN TORSIONAL SISTEM PROPULSI

Getaran torsional adalah getaran yang arah gerakannya berupa rotasi, yang dimana searah dengan rotasi dari rotor atau motor. Getaran torsional terjadi akibat ekstasi torsi atau momen. Getaran torsional mendapat perhatian lebih pada sistem propulsi khususnya pada poros *propeller*. Karena getaran torisonal yang berlebih dapat menyebabkan kelelahan atau *fatigue* pada poros *propeller*. secara umum

model getaran torsional pada sistem propulsi dapat dimodelkan seperti dibawah ini:



Gambar 4.2 Getaran Torsional

(<http://www.dewesoft.com/pro/course/rotational-and-torsional-vibration-34>)

Berdasarkan uraian getaran torsional pada sistem propulsi pada dasar teori sebelumnya. Berikut rincian dari perhitungan getaran torsional pada KMP. Dharma Ructira:

A. Perhitungan Frekuensi Eksitasi

$$\omega = 2\pi \frac{RPM}{60} N \text{ (rad/s)}$$

Diketahui data sebagai berikut:

RPM Mesin Induk : 250

*Pada spesifikasi mesin induk, RPM yang tertera adalah 400 RPM. Namun, pada kondisi sesungguhnya, mesin induk sudah tidak mampu mencapai kondisi RPM tersebut.

Jumlah Daun *Propeller* : 4

Sehingga,

$$\omega = 2 \times 3,14 \frac{250}{60} 4$$

$$\omega = 104,67 \text{ rad/s}$$

B. Perhitungan Frekuensi Natural

Dimana harus dicari terlebih dahulu nilai dari Kekakuan Pegas (K),

$$\omega_n = \frac{1}{2\pi} \sqrt{\frac{k}{J}} \text{ (rad/s)}$$

K = Kekakuan pegas (N/m)

$$k = \frac{G \times Ja}{l}$$

Diketahui:

G = Modulus Geser Baja = $79,3 \times 10^9 N/m^2$

Ja = Momen inertia luas

$$Ja = \frac{\pi \times r^4}{2}$$

$$Ja = \frac{3,14 \times 0,75^4}{2}$$

$$Ja = 0,496 \text{ m}$$

l = 16,1 m

sehingga didapatkan nilai dari kekakuan pegas adalah:

$$k = \frac{79,3 \times 10^9 \times 3,23 \times 10^{-3}}{16,1} = 15,1 \times 10^6$$

Setelah itu mencari nilai dari momen inertia massa (J). Dimana momen inertia massa bisa didapatkan dari:

$$J = 1,25 J_{propeller} \times 0,3 J_{poros}$$

Perhitungan $J_{Propeller}$

$$J_{Propeller} = 0,25r^2 \times \text{massa propeller}$$

Diketahui:

$$r_{Propeller} = 750 \text{ mm} = 0,213 \text{ ft}$$

$$m_{Propeller} = 275 \text{ Kg}$$

sehingga didapatkan nilai dari $J_{Propeler}$ adalah:

$$J_{Propeller} = 0,25(0,75)^2 \times 275$$

$$J_{Propeller} = 38,672$$

Perhitungan J_{poros}

$$J_{Poros} = Ja \times l_{Poros}$$

$$J_{Poros} = 0,496 \times 16,1$$

$$J_{Poros} = 7,985$$

Sehingga nilai besaran dari momen inertiya massa adalah:

$$J = 1,25 J_{propeller} \times 0,3 J_{poros}$$

$$J = 1,25 (38,672) \times 0,3(7,985)$$

$$J = 115,798$$

Didapatkan nilai dari frekuensi natural sistem adalah sebagai berikut:

$$\omega_n = \frac{1}{2\pi} \sqrt{\frac{k}{J}} \text{ (rad/s)}$$

$$\omega_n = \frac{1}{2(3,14)} \sqrt{\frac{15,1 \times 10^6}{115,798}} \text{ (rad/s)}$$

$$\omega_n = 56,501 \text{ (rad/s)}$$

C. Perhitungan Osilasi Torsi

$$\frac{M_s}{Q_o} = \frac{\beta}{\sqrt{\left[1 - \left(\frac{\omega}{\omega_n}\right)^2\right]^2 + \left[2\zeta \frac{\omega}{\omega_n}\right]^2}}$$

Dimana diketahui:

ζ = koefisien redaman.

$$\zeta = \frac{C}{2 \times J \times \omega_n}$$

C = Koefisien damping

$$C = 39 \times r_{propeller}$$

J = Momen Inertia Massa (N)

Sehingga didapatkan nilai dari koefisien redaman adalah:

$$\zeta = \frac{C}{2 \times J \times \omega_n}$$

Diketahui:

$$C = 95,94$$

$$J = 115,798$$

$$\omega n = 56,501 \text{ rad/s}$$

$$\zeta = \frac{95,94}{2 \times 115,798 \times 56,501}$$

$$\zeta = 0,00733$$

Setelah itu bisadidapatkan nilai dari osilasi torsi adalah:

$$\frac{M_s}{Q_o} = \frac{\beta}{\sqrt{\left[1 - \left(\frac{\omega}{\omega n}\right)^2\right]^2 + \left[2\zeta \frac{\omega}{\omega n}\right]^2}}$$

Diketahui:

β adalah persentase besarnya amplitudo eksitasi. Besarnya nilai β sendiri berkisar antara 0% -15%, tergantung dari permukaan buritan dan desain daun *propeller*.

Pada perhitungan ini diambil nilai dari β sebesar 7,5%.

$$\beta = 0,075$$

$$\zeta = 0,00733$$

$$\frac{M_s}{Q_o} = \frac{0,075}{\sqrt{\left[1 - \left(\frac{104,67}{56,501}\right)^2\right]^2 + \left[2(0,00733) \frac{104,67}{56,501}\right]^2}}$$

$$\frac{M_s}{Q_o} = 0,0127$$

4.3 PERHITUNGAN TEGANGAN GETARAN TORSIONAL

Tegangan getaran torsional pada poros adalah dampak yang disebabkan oleh getaran torsional pada sistem propulsi. pada perhitungan ini stress getaran torsional hanya dilakukan pada poros *propeller*. karena poros *propeller* mengalami tegangan paling besar akibat dari dampak dari getaran torsional tersebut. berikut rincian dari perhitungan dari stress getaran torsional:

A. Perhitungan τ_1

Pertama dicari dahulu nilai dari tegangan getaran torsional pada kondisi operasi secara terus menerus (τ_1). Pada kapal KMP. Dharma Rucitra speed ratio berkisar 0,8. Sehingga menggunakan persamaan 2.17:

$$\tau_1 = \pm C_w \times C_k \times C_d \times (3 - 2\lambda^{-2})$$

Dimana diketahui nilai dari:

C_w = Material Baja

$$= (R_m + 160) / 18$$

$$= (420 + 160) / 18$$

$$= 32,22$$

$$C_k = 1,0 \text{ (Koefesien } Intermediate \text{ Shfat)}$$

$$C_d = 0,35 + (0,93 \times d^{-0,2})$$

$$= 0,35 + (0,93 \times 130^{-0,2})$$

$$= 0,7034$$

$$\lambda = 0,8 \text{ (speed ratio)}$$

Sehingga didapatkan nilai dari tegangan getaran torsional pada poros pada kondisi operasi secara terus menerus adalah:

$$\tau_1 = \pm 32,22 \times 1 \times 2,812 \times (3 - 2 (0,8)^2)$$

$$\tau_1 = \pm 38,98 \text{ N/mm}^2$$

B. Perhitungan τ_2

Setelah mendapatkan tegangan getaran torsional pada kondisi operasi secara sementara, selanjutnya mencari nilai dari tegangan torsional pada kondisi tertentu (τ_2) dengan menggunakan persamaan 2.20. Sebagai berikut:

$$\tau_2 = \pm 1,7 \times 6,0 \times \frac{\tau_1}{\sqrt{Ck}}$$

Dimana diketahui nilai dari:

$$\begin{aligned} C_w &= \text{Material Baja} \\ &= (R_m + 160) / 18 \\ &= (420 + 160) / 18 \\ &= 32,22 \end{aligned}$$

$$C_k = 1,0 \text{ (Koefesien } \textit{Intermediate Shfat})$$

$$\tau_1 = 38,98 \text{ N/mm}^2$$

Sehingga didapatkan nilai dari tegangan getaran torsional pada poros pada kondisi operasi secara terus menerus adalah:

$$\tau_2 = \pm 1,7 \times 6,0 \times \frac{19,399}{\sqrt{1,0}}$$

$$\tau_2 = \pm 66,268 \text{ N/mm}^2$$

4.4 PENGUKURAN GETARAN

Pengukuran dilakukan secara langsung pada kamar mesin kapal KMP. Dharma Rucitra berdasarkan titik-titik yang telah ditentukan sebelumnya. Pada pengukuran kali dilakukan pengukuran sebanyak sembilan kali yang memakan waktu selama tiga hari lamanya. Pada pengukuran ini ditekankan pada pondasi kamar mesin, *clutch* dan *plummer block*. Proses pengukuran dilakukan pada saat operasional berlangsung (Ketapang –

Gilimanuk). Berikut gambar objek tempat pengujian tingkat getaran sesuai dengan titik-titik yang telah ditentukan.



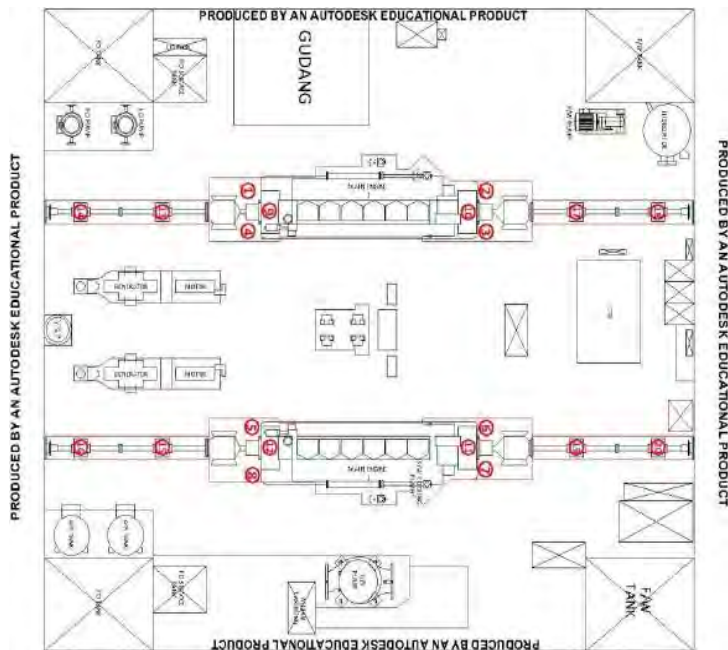
Gambar 4.3 Pondasi Mesin Induk



Gambar 4.4 Clutch



Gambar 4.5 Plummer Block



Gambar 4.6 Titik-Titik Pengukuran Tingkat Getaran

Berikut dilampirkan data hasil pengukuran tingkat getaran kamar mesin KMP. Dharma Rucitra.

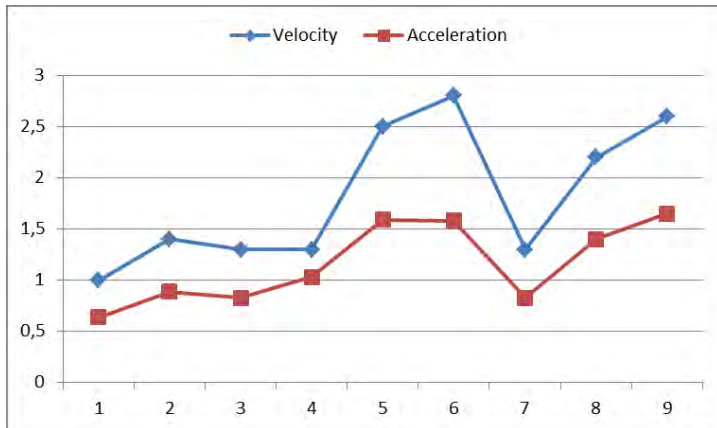
Tabel 4.1 Data Pengukuran Getaran pada Titik 1 hingga 10

Titik	Data Pengukuran									Satuan	Mean
	1	2	3	4	5	6	7	8	9		
1	1	1,4	1,3	1,3	2,5	2,8	1,3	2,2	2,6	Velocity	1,82
	0,64	0,89	0,83	0,83	1,59	1,78	0,83	1,4	1,65	Acceleration	1,16
2	1,3	1,6	1,1	1,3	1,8	1,2	1,4	1,3	1,1	Velocity	1,34
	0,83	1,02	0,7	0,83	1,14	0,76	0,89	0,83	0,7	Acceleration	0,86
3	1,6	1,6	1,1	1,4	0,8	1,3	1,5	2,3	1,5	Velocity	1,46
	1,02	1,02	0,7	0,89	0,51	0,83	0,95	1,46	0,95	Acceleration	0,93
4	1,6	2,7	3,2	2	4,8	5,3	4,5	4,6	1,7	Velocity	3,38
	1,02	1,71	2,03	1,27	3,05	3,36	2,86	2,92	1,08	Acceleration	2,14
5	1,2	1,1	1,1	1,2	1,1	1,9	1,2	2	1	Velocity	1,31
	0,76	0,7	0,7	0,76	0,7	1,21	0,76	1,27	0,64	Acceleration	0,83
6	1,7	1,9	1,7	1,6	1,3	1,2	1,6	1,7	1,3	Velocity	1,56
	1,08	1,21	1	1,02	0,83	0,76	1,02	8	0,83	Acceleration	1,75
7	1,3	1,3	1,3	1	1,1	1,2	0,9	1,1	1	Velocity	1,13
	0,83	0,83	0,83	0,64	0,7	0,76	0,57	0,7	0,64	Acceleration	0,72
8	1,2	1,1	1,1	1,8	1	1,4	1,1	1,2	0,9	Velocity	1,20
	0,76	0,7	0,7	1,14	0,64	0,89	0,7	0,76	0,57	Acceleration	0,76
9	2,2	2	2,2	2,3	2,6	2,9	2,5	2,6	1,7	Velocity	2,33
	1,4	1,27	1,4	1,46	1,65	1,84	1,59	1,65	1,08	Acceleration	1,48
10	3,3	2,8	1,6	2,1	1,8	3,5	2,2	2,4	3,1	Velocity	2,53
	2,09	1,78	1,02	1,33	1,14	2,22	1,4	1,33	1,97	Acceleration	1,59

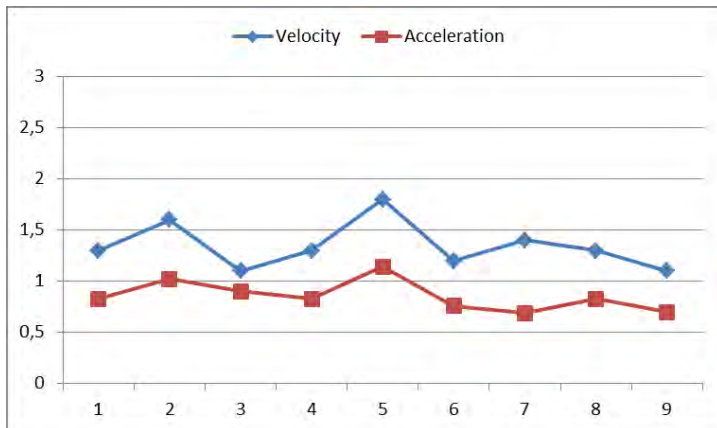
Tabel 4.2 Data Pengukuran Getaran pada Titik 11 hingga 20

Titik	Data Pengukuran									Satuan	Mean
	1	2	3	4	5	6	7	8	9		
11	4,6	5,4	4	5,4	3,2	3,7	7,6	8,3	8,7	Velocity	5,66
	2,92	3,43	2,54	3,43	2,03	2,35	4,82	5,27	5,52	Acceleration	3,59
12	3,1	3,4	2,6	2,7	4,5	2,9	4,5	2,8	3,3	Velocity	3,31
	1,97	2,16	1,65	1,71	2,86	1,84	2,86	1,78	2,09	Acceleration	2,10
13	1,3	1,9	0,9	1,7	2,2	3,4	1,1	2,5	1	Velocity	1,78
	0,83	1,21	0,57	1,08	1,4	2,16	0,7	1,59	0,64	Acceleration	1,13
14	0,9	1,7	0,8	1,2	2	2,8	1,2	2,3	1	Velocity	1,54
	0,57	1,08	0,51	0,76	1,27	1,78	0,76	1,46	0,64	Acceleration	0,98
15	1,6	1,2	1,2	1	1,3	1,9	1,5	1,6	1	Velocity	1,37
	1,02	0,76	0,76	0,64	0,83	1,21	0,95	1,02	0,64	Acceleration	0,87
16	0,8	1,1	0,9	1	0,7	1,2	0,9	1,2	0,8	Velocity	0,96
	0,51	0,7	0,57	0,64	0,44	0,76	0,57	0,76	0,51	Acceleration	0,61
17	1,4	1,6	1,2	1,1	1,4	1,7	1,1	1,5	1,5	Velocity	1,39
	0,89	1,02	0,76	0,7	0,53	1,08	0,7	0,95	0,95	Acceleration	0,84
18	1,3	0,7	4,6	2,1	1,6	4,7	6,1	3	0,9	Velocity	2,78
	0,83	0,44	2,92	1,33	1,02	2,98	3,87	1,9	0,57	Acceleration	1,76
19	1,2	1,1	0,9	1	0,9	1,8	0,7	1,6	1,2	Velocity	1,16
	0,76	0,7	0,57	0,64	0,57	1,14	0,44	1,02	0,76	Acceleration	0,73
20	0,8	1	0,8	0,8	0,7	1,7	0,8	1,3	1	Velocity	0,99
	0,51	0,64	0,51	0,51	0,44	1,08	0,51	0,83	0,64	Acceleration	0,63

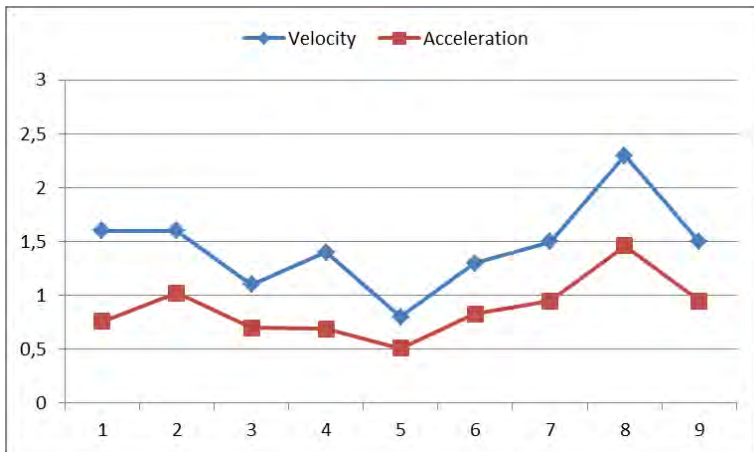
Berikut dilampirkan pula grafik tingkat getaran pada titik-titik yang dilakukan pengukuran tingkat getaran:



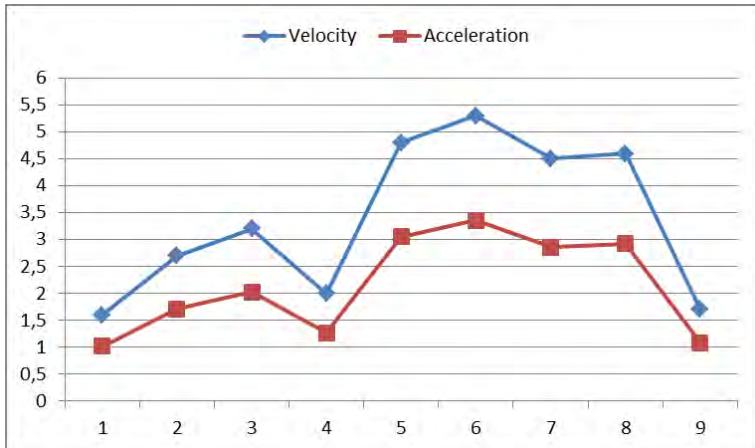
Grafik 4.1 Data Pengukuran Getaran pada Titik 1



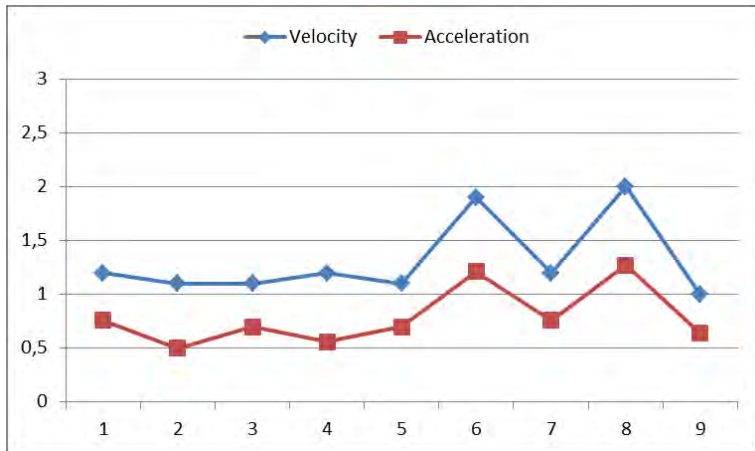
Grafik 4.2 Data Pengukuran Getaran pada Titik 2



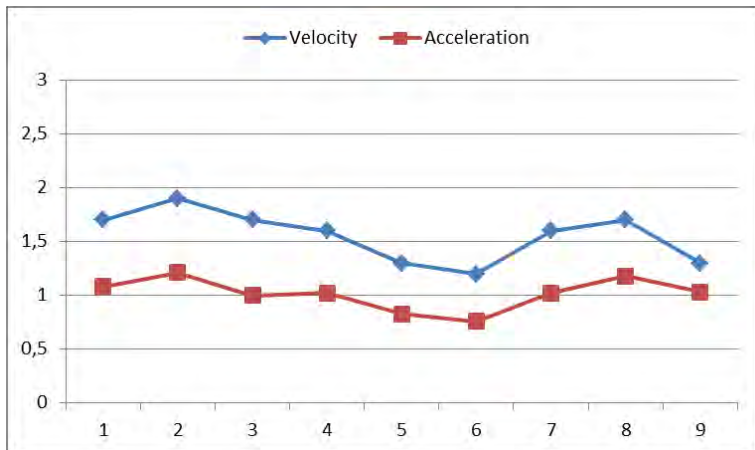
Grafik 4.3 Data Pengukuran Getaran pada Titik 3



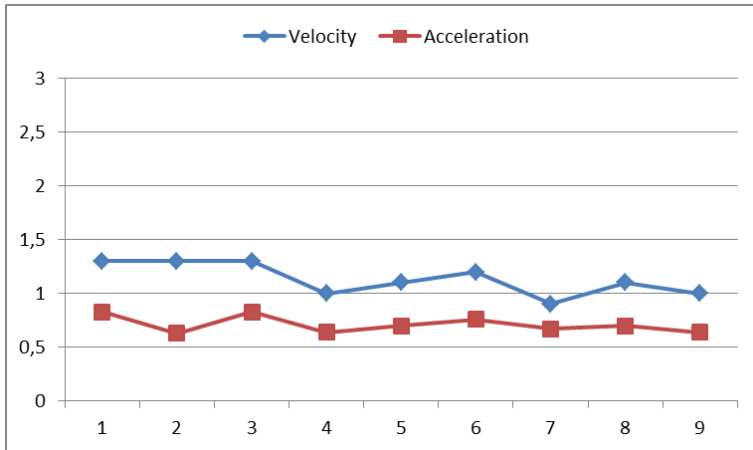
Grafik 4.4 Data Pengukuran Getaran pada Titik 4



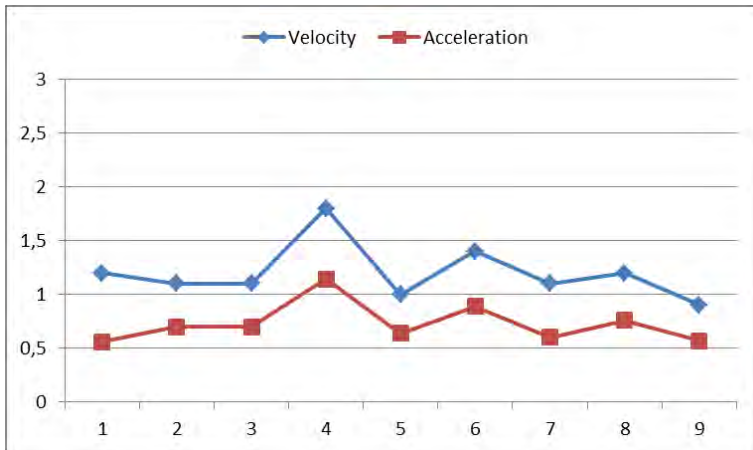
Grafik 4.5 Data Pengukuran Getaran pada Titik 5



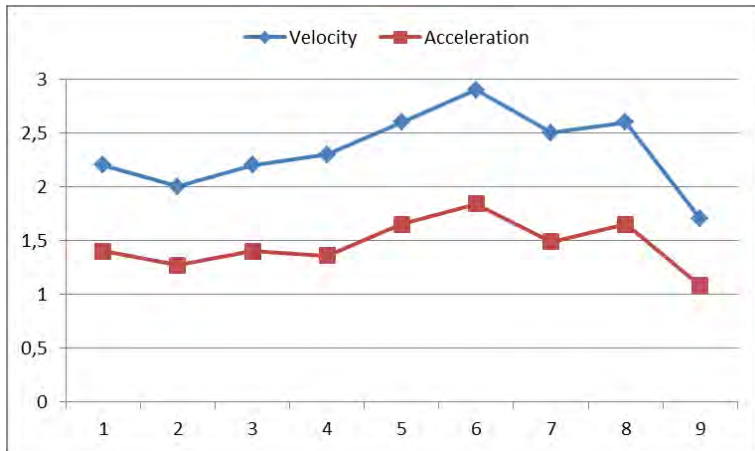
Grafik 4.6 Data Pengukuran Getaran pada Titik 6



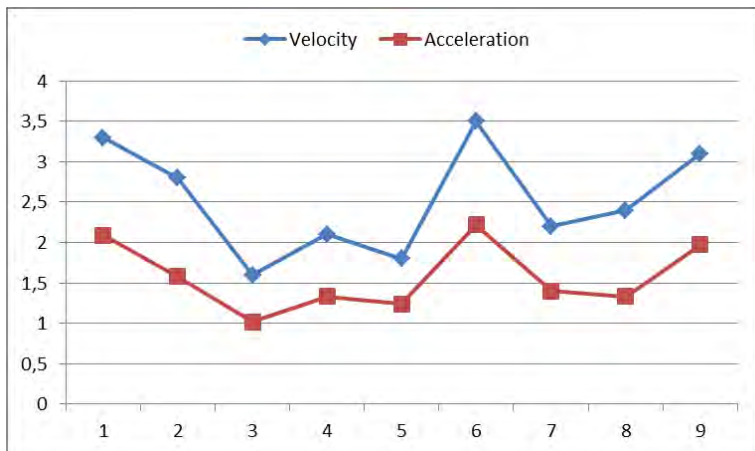
Grafik 4.7 Data Pengukuran Getaran pada Titik 7



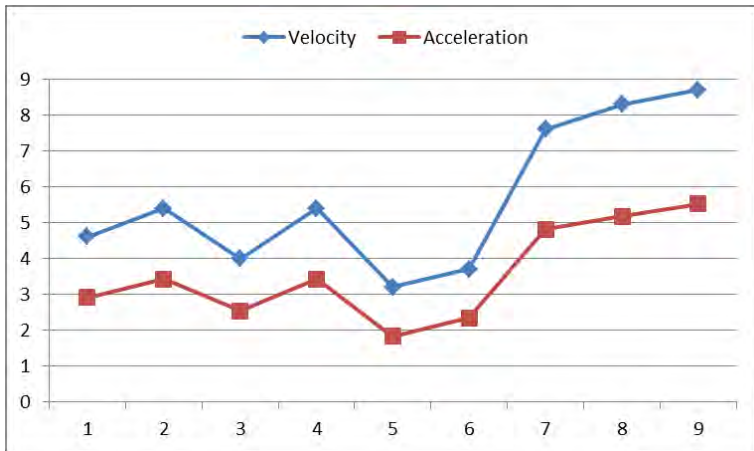
Grafik 4.8 Data Pengukuran Getaran pada Titik 8



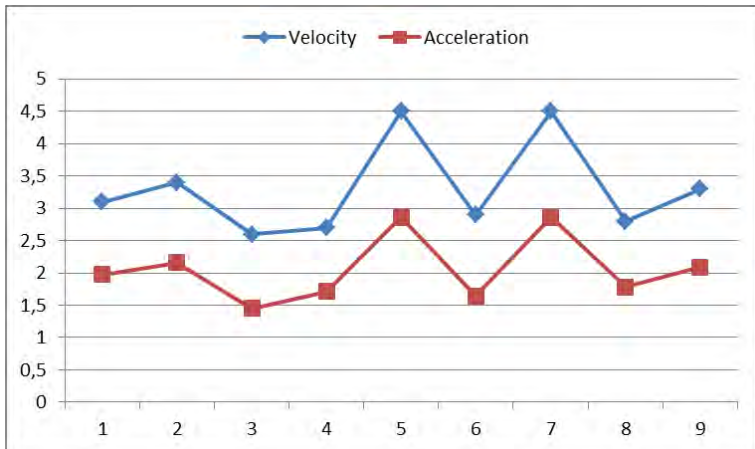
Grafik 4.9 Data Pengukuran Getaran pada Titik 9



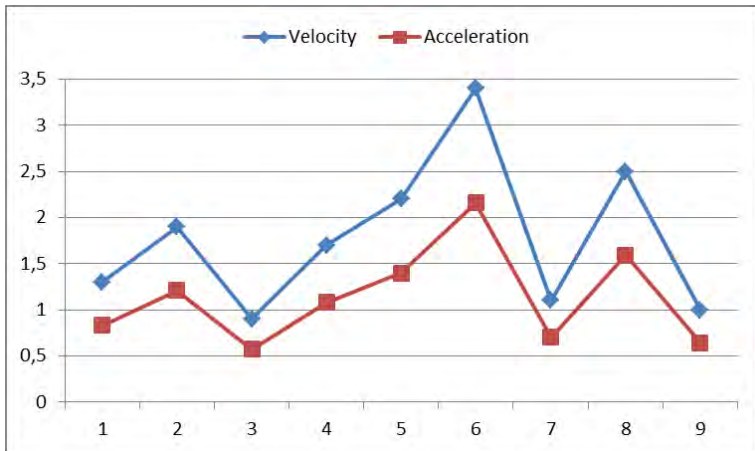
Grafik 4.10 Data Pengukuran Getaran pada Titik 10



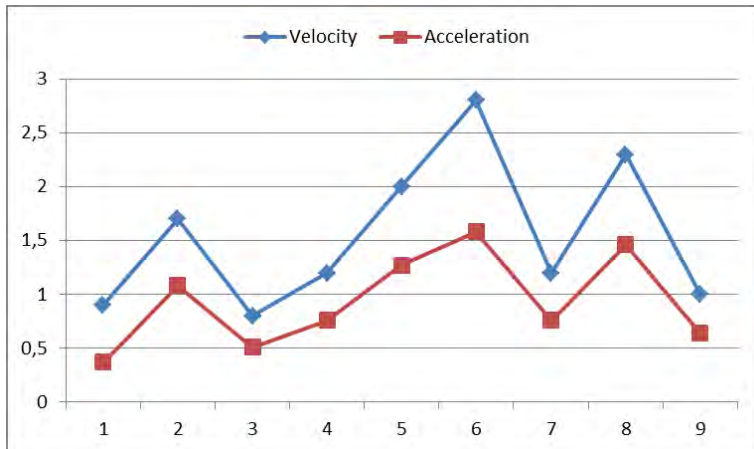
Grafik 4.11 Data Pengukuran Getaran pada Titik 11



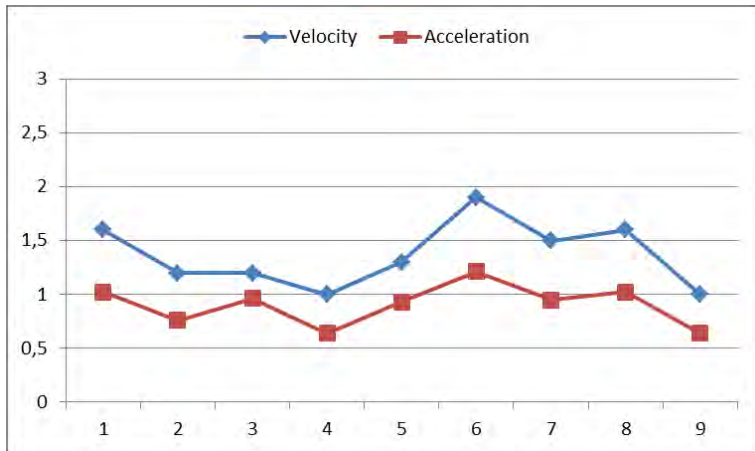
Grafik 4.12 Data Pengukuran Getaran pada Titik 12



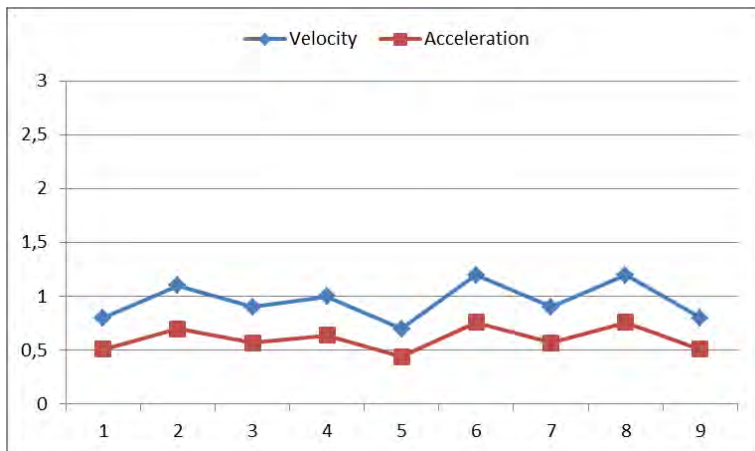
Grafik 4.13 Data Pengukuran Getaran pada Titik 13



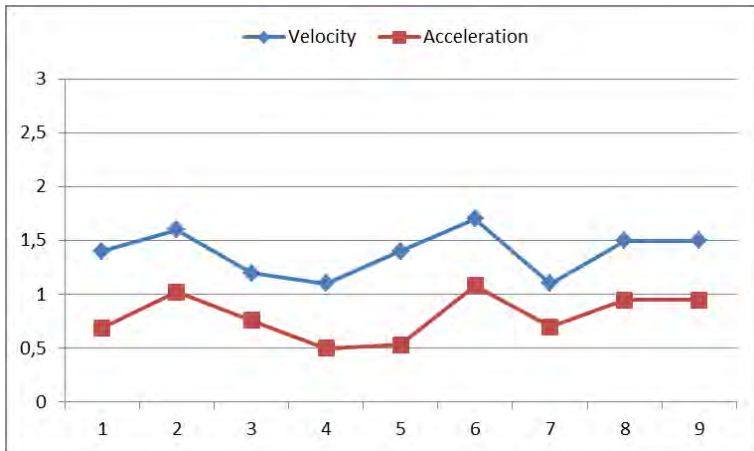
Grafik 4.14 Data Pengukuran Getaran pada Titik 14



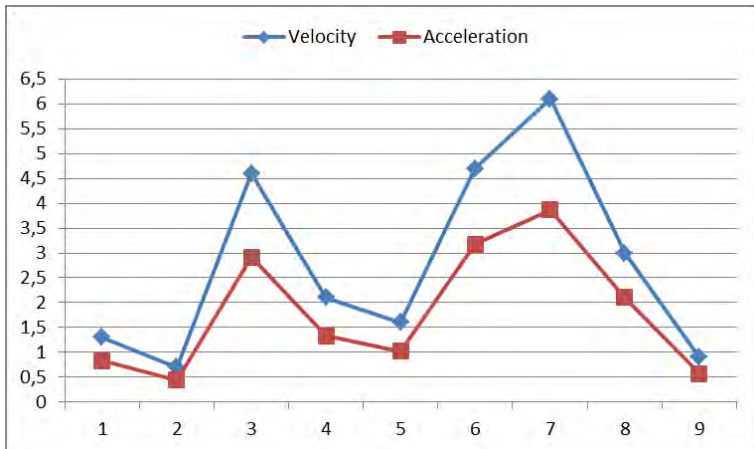
Grafik 4.15 Data Pengukuran Getaran pada Titik 15



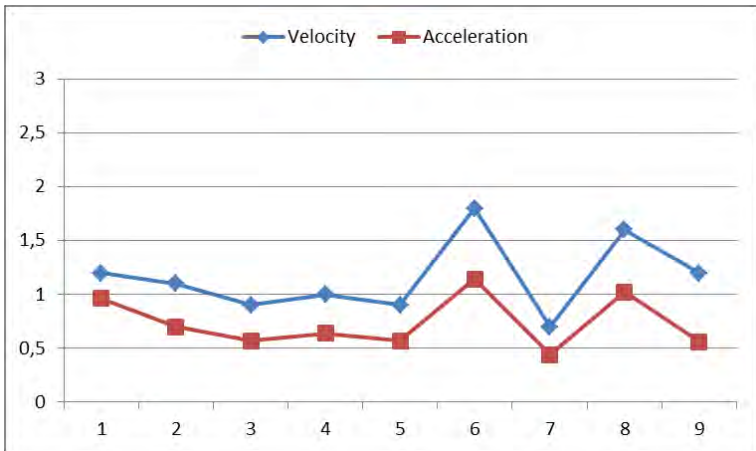
Grafik 4.16 Data Pengukuran Getaran pada Titik 16



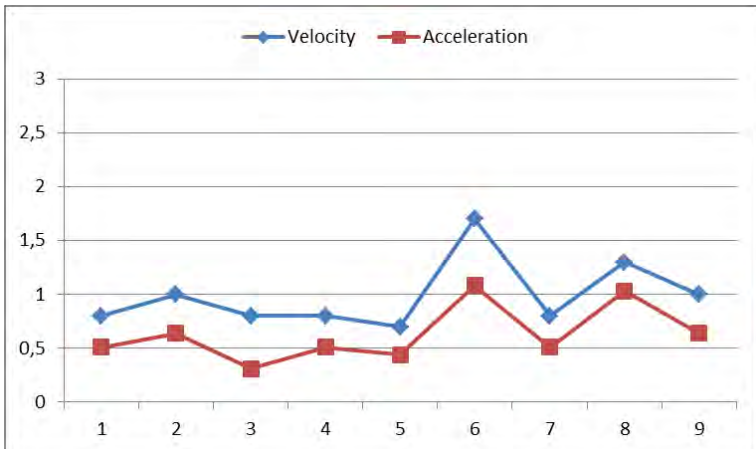
Grafik 4.17 Data Pengukuran Getaran pada Titik 17



Grafik 4.18 Data Pengukuran Getaran pada Titik 18



Grafik 4.19 Data Pengukuran Getaran pada Titik 19



Grafik 4.20 Data Pengukuran Getaran pada Titik 20

Dari data hasil pengukuran tingkat getaran secara langsung pada titik-titik yang ditentukan sebelumnya dapat dilihat bahwasannya setiap titik memiliki besaran tingkat getaran yang berbeda-beda. Getaran yang terjadi pada objek tersebut menunjukkan tingkat getaran dari longitudinal dan torsional. Dari hasil pengukuran tersebut akan dilakukan rata-rata besaran tingkat getaran pada mesin induk, *clutch* dan *plummer block*. Berikut hasil rata-rata tingkat getaran pada objek yang dilakukan pengukuran:

Tabel 4.3 Hasil rata-rata tingkat getaran

No.	Komponen	Mean	
1	Main Engine 1	1,3	mm/s
		0,81	m/s ²
2	Clutch 1	5,66	mm/s
		3,56	m/s ²
3	Clutch 2	3,31	mm/s
		2,06	m/s ²
4	Plummer Block 1	0,99	mm/s
		0,63	m/s ²
5	Plummer Block 2	1,16	mm/s
		0,73	m/s ²
6	Plummer Block 3	1,37	mm/s
		0,9	m/s ²
7	Plummer Block 4	0,96	mm/s
		0,61	m/s ²
8	Main Engine 2	2	mm/s
		1,26	m/s ²
9	Clutch 3	2,53	mm/s
		1,58	m/s ²
10	Clutch 4	2,33	mm/s
		1,46	m/s ²
11	Plummer Block 5	2,78	mm/s

		1,81	m/s^2
12	Plummer Block 6	1,39	mm/s
		0,8	m/s^2
13	Plummer Block 7	1,78	mm/s
		1,13	m/s^2
14	Plummer Block 8	1,54	mm/s
		0,94	m/s^2
15	Total	1,95	mm/s
		1,22	m/s^2

4.5 PENGECEKKAN STANDART DAN ATURAN

Setelah dilakukan perhitungan secara manual dan pengukuran secara langsung pada tingkat getaran kamar mesin kapal KMP. Dharma Rucitra, selanjutnya dilakukan analisa dari hasil tersebut terhadap standart dan aturan yang berlaku.

4.5.1 PENGECEKKAN STANDART DAN ATURAN GETARAN

Pada pengecekan standart tingkat getaran menggunakan tiga standart yang berlaku:

1. ABS (*American Bureau of Shipping*)
2. ISO 2631
3. Keputusan Menteri Ketenaga Kerjaan Republik Indonesia No.51 Tahun 1999

4.5.1.1 ABS (*American Bureau of Shipping*)

Pada standart ABS menyatakan bahwa:

“Amplitudo eksitasi pada getaran torsional pada kapal yang menggunakan *twin screw* rata-rata adalah 0,022To untuk *propeller* dengan jumlah daun 4, 0,017To untuk *propeller* dengan

jumlah daun 5 dan 0,015To untuk *propeller* dengan jumlah daun 6”

Berdasarkan perhitungan manual terhadap getaran longitudinal sistem propulsi kapal KMP. Dharma Rucitra didapatkan nilai sebesar 0,217.

Sehingga,

$$0,217 < 0,022To$$

Dari perhitungan secara manual dapat ditarik kesimpulan bahwasannya nilai dari getaran longitudinal pada kapal KMP. Dharma Rucitra menurut standart ABS masih dibawah standart yang diizinkan atau masih dibawah standart yang telah ditentukan.

Sedangkan untuk getaran torsional, ABS menyatakan bahwa:

“Torsi getaran atau torsi yang berosilasi pada kapal yang menggunakan *twin screw* memiliki rata-rata torsi sebesar 0,016 pada 4 baling-baling, 0,0014 pada 5 baling-baling dan 0,0010 pada 6 baling-baling”

Berdasarkan perhitungan manual terhadap getaran torsional sistem propulsi kapal KMP. Dharma Rucitra didapatkan nilai sebesar 0,0127.

Sehingga,

$$0,0127 < 0,016$$

Dari perhitungan secara manual dapat ditarik kesimpulan bahwasannya nilai dari getaran torsional pada KMP. Dharma

Rucitra menurut standar ABS, masih dibawah standart yang telah ditentukan.

Selanjutnya membandingkan hasil pengukuran secara langsung pada kamar mesin KMP. Dharma Rucitra terhadap standart ABS. Berdasarkan standart ABS, dimana diatur mengenai nilai ambang batas getaran dari komponen mesin propulsi. Berikut nilai ambang batas mesin propulsi pada ABS:

Tabel 4.4 Nilai ambang batas getaran pada mesin propulsi.

<i>Propulsion Machinery</i>	<i>Limits (RMS)</i>
<i>Thrust bearing and bull gear hub</i>	5 mm/s
Other propulsiion machinery component	13 mm/s
Stern tube and line shaft bearing	7 mm/s
Diesel engine at bearing	13 mm/s
Slow & medium speed diesel engine (over 1000 hp)	18 mm/s
High speed diesel engine (less 1000 hp)	13 mm/s

Dari data hasil data pengukuran secara langsung dapat ditarik kesimpulan sebagai berikut:

Tabel 4.5 Perbandingan nilai hasil pengukuran terhadap standart ABS.

No.	Komponen	Hasil Pengukuran	Standart ABS	Status
1	Main Engine 1	1,3 mm/s	13 mm/s	Memenuhi
2	Clutch 1	5,66 mm/s	13 mm/s	Memenuhi
3	Clutch 2	3,31 mm/s	13 mm/s	Memenuhi
4	Plummer Block 1	0,99 mm/s	7 mm/s	Memenuhi

5	Plummer Block 2	1,16 mm/s	7 mm/s	Memenuhi
6	Plummer Block 3	1,37 mm/s	7 mm/s	Memenuhi
7	Plummer Block 4	0,96 mm/s	7 mm/s	Memenuhi
8	Main Engine 2	2 mm/s	13 mm/s	Memenuhi
9	Clutch 3	2,53 mm/s	13 mm/s	Memenuhi
10	Clutch 4	2,33 mm/s	13 mm/s	Memenuhi
11	Plummer Block 5	2,78 mm/s	7 mm/s	Memenuhi
12	Plummer Block 6	1,39 mm/s	7 mm/s	Memenuhi
13	Plummer Block 7	1,78 mm/s	7 mm/s	Memenuhi
14	Plummer Block 8	1,54 mm/s	7 mm/s	Memenuhi

Dari data perbandingan tersebut didapatkan bahwasannya seluruh titik-titik yang digunakan sebagai objek pengukuran getaran pada kapal KMP. Dharma Rucitra masih dalam batas yang diizinkan dalam standart ABS.

Selanjutnya membandingkan nilai tingkat getaran terhadap ABK atau *crew* kapal. Dimana pada ABS diatur nilai dari pengaruh getaran terhadap ABK kapal sebagai berikut:

Tabel 4.6 Nilai ambang batas getaran terhadap ABK Kapal.

ABS Optional Notation	Freq. Range	Maximum Level
HAB/COMF	0,5 – 80 Hz	0,4 m/s ²
HAB+/COMF+	0,5 – 80 Hz	0,315 m/s ²

Berdasarkan dari hasil pengukuran secara langsung terhadap seluruh titik-titik yang digunakan sebagai objek pengukuran pada kamar mesin KMP. Dharma Rucitra, didapatkan nilai rata-rata dari keseluruhan titik tersebut sebesar $1,22 \text{ m/s}^2$. Jika menurut standart ABS, nilai tingkat getaran tersebut terhadap ABK jauh diatas dari batas yang diizinkan. Jadi getaran pada ruang kamar mesin tidak memenuhi terhadap ABK atau *crew* kapal.

4.5.1.2 ISO 2631 (*Mechanical Vibration and Shock Evaluation of Human Exposure to Whole Body Vibration*)

ISO 2631 lebih menekankan dampak atau efek dari tingkat getaran terhadap kenyamanan dan keamanan bagi pekerja. Orang yang terkena getaran yang berlebih secara terus menerus atau kontinyu dapat mempengaruhi produktifitas kerja karena akan mengalami kelelahan.

Tabel 4.7 Nilai Ambang Batas Getaran Terhadap Tubuh bagi Pekerja

<i>Scale</i>	Mean Magnitude (m/s^2)
Extremely Uncomfortable	<i>Greater than 2</i>
Very Uncomfortable	1,25 – 2
Uncomfortable	0,8 – 1,6
Fairly Uncomfortable	0,5 – 1
A Little Comfortable	0,315 – 0,63
Comfortable	Less than 0,315

Pada pengecekan standart menggunakan ISO ini menggunakan dari hasil nilai rata-rata pengukuran getaran secara langsung. Nilai rata-rata getaran pada pengukuran secara

langsung didapatkan nilai sebesar $1,22 \text{ m/s}^2$. Jika mengacu pada standart ISO 2631, tingkat getaran pada kamar mesin KMP. Dharma Rucitra masuk dalam golongan “*uncomfortbale*” atau tidak nyaman bagi pekerja atau ABK Kapal yang berada kamar mesin.

4.5.1.3 KEPUTUSAN MENTERI TENAGA KERJA RI No. 51 Tahun 1999

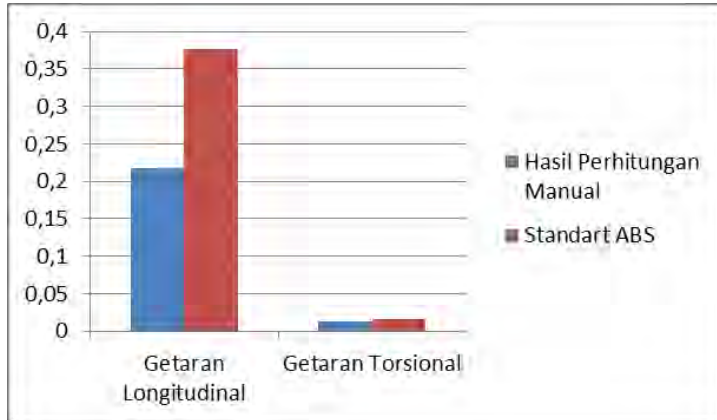
Keputusan Menteri ini mengatur nilai ambang batas fisika pada tempa kerja. Yang dimana tidak jauh berbeda dengan standart ISO, dimana objek pengukuran getaran ditekankan pada pekerja. Berikut nilai ambang batas fisika yang diatur dalam Keputusan Menteri Tenaga Kerja No.51 Tahun 1999:

Tabel 4.8 Nilai Ambang Batas Getaran Menurut Keputusan Meneteri Tenaga Kerja No.51 Tahun 1999

Waktu	Magnitude (m/s^2)
4 jam dan kurang dari 8 jam	4 m/s^2
2 jam dan kurang dari 4 jam	6 m/s^2
1 jam dan kurang dari 2 jam	8 m/s^2
Kurang dari 1 jam	12 m/s^2

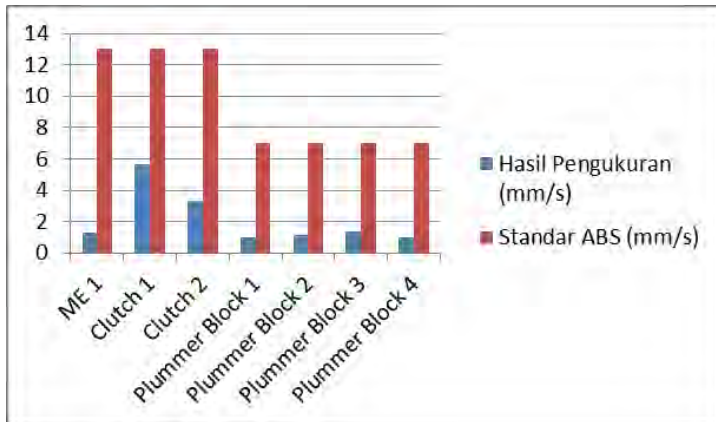
Nilai rata-rata tingkat getaran pada kamar mesin KMP. Dharma Rucitra sebesar $1,22 \text{ m/s}^2$. Dimana waktu kerja ABK atau pergantian shift kerja pada kamar mesin berkisar kurang lebih 8 jam. Sehingga jika merujuk pada poit pertama, maka nilai tingkat getaran pada kamar mesin KMP. Dharma Rucitra masih dibawah ambang batas Keputusan Menteri Tenaga Kerja no.51 Tahun

1999. Sehingga masih memenuhi terhadap standart yang telah ditentukan.

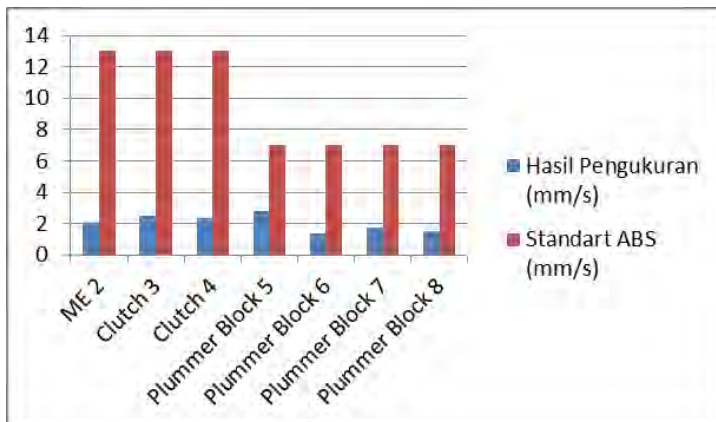


Grafik 4.21 Perbandingan hasil perhitungan getaran secara manual dengan standart ABS.

Analisa getaran untuk berdasarkan perhitungan manual, dari hasil perhitungan secara manual berdasarkan teori getaran longitudinal dan getaran torsional, didapatkan nilai dari amplitudo eksitasi getaran longitudinal pada sistem propulsi kapal KMP. Dharma Rucitra adalah sebesar 0,217. Sedangkan nilai dari osilasi torsi getaran torsional pada sistem propulsi kapal KMP. Dharma Rucitra sebesar 0,0127 Q_0 . Hasil tersebut menyatakan bahwa nilai dari getaran torsional dan getaran longitudinal masih memenuhi standart ABS, yaitu tidak lebih dari 0,25g untuk nilai getaran longitudinal dan tidak lebih dari 0,16 untuk getaran torsional.



Grafik 4.22 Perbandingan hasil pengukuran getaran dengan standar ABS (1)



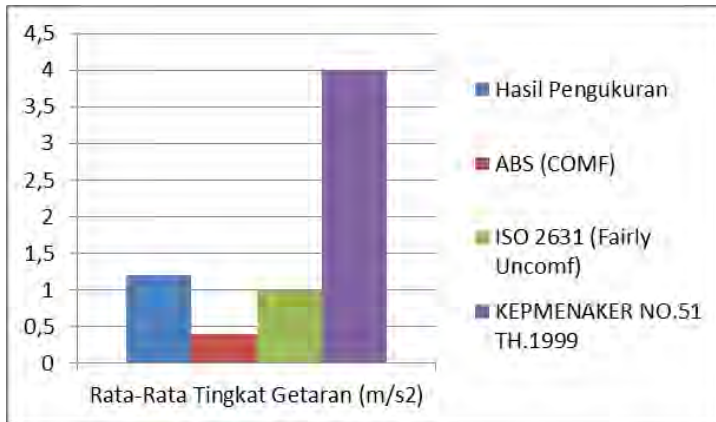
Grafik 4.23 Perbandingan hasil pengukuran getaran dengan standar ABS (2)

Sedangkan untuk analisa getaran melalui pengukuran secara langsung menggunakan alat *vibration meter*, pada kamar mesin KMP. Dharma Rucitra didapatkan bahwa seluruh titik-titik

yang dilakukan pengukuran masih memenuhi standart yang diatur. Namun terdapat perbedaan nilai rata-rata yang cukup signifikan dari getaran torsional dan getaran longitudinal yang terletak pada titik ke 11. Titik 11 merupakan *Clutch no. 1*, dimana nilai rata-rata getarannya mencapai 5,66 mm/s. Walaupun nilai tersebut masih memenuhi standart yang telah ditentukan, namun nilai tersebut harus menjadi perhatian khusus. Karena nilai getaran pada *clutch no. 1* berbeda cukup jauh dengan nilai getaran pada titik-titik lainnya yang dilakukan pengukuran.

Ini menjadi indikasi awal bahwasannya telah terjadi anomali terhadap *clutch no.1*. sehingga perlu dilakukan pengecekan pada bagian tersebut. Getaran yang besar yang terjadi pada *clutch no.1* Bisa terjadi karena *clutch* mengalami aus. Selain itu juga bisa terjadi karena *clearance* antara *clutch disc* dengan *plate (shaft)* sudah melebihi batas yang diizinkan. Dan juga bisa terjadi karena *clutch disc* dan *shaft propeller* tidak sejajar atau tidak lurus akibat mengalami deformasi yang menyebabkan timbulnya getaran berlebih. Hal tersebut bisa dilakukan pengecekan dengan melakukan pada bagian poros *propeller*.

Namun tingkat getaran yang terjadi pada kamar mesin KMP. Dharma Rucitra jika mengacu pada standar yang berhubungan dengan efek getaran terhadap pekerja atau ABK kapal, dalam hal ini mengacu ABS, ISO dan Keputusan Menteri Tenaga Kerja Repeublik Indonesia. Hanya pada Keputusan Meteri Tenaga Kerja Republik Indonesia sajalah yang masih memenuhi standar tingkat getaran dari kamar mesin KMP. Dharma Rucitra.



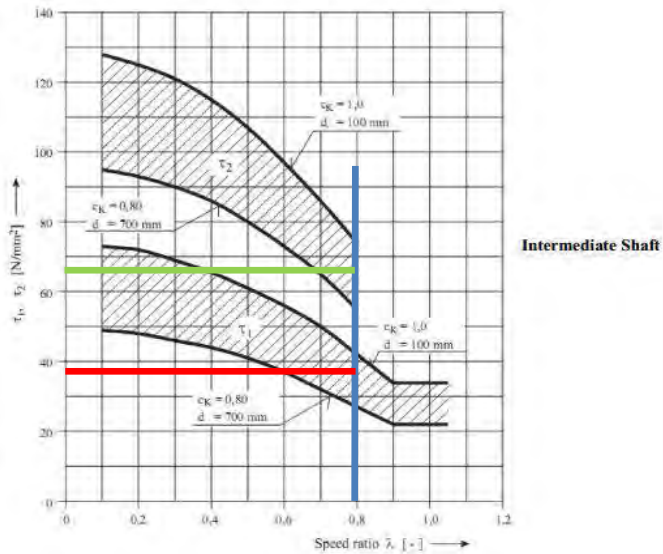
Grafik 4.24 Perbandingan rata-rata hasil pengukuran terhadap kenyamanan bagi pekerja.

4.5.2 PENGECEKKAN STANDAR TEGANGAN GETARAN TORSIONAL.

Pengecekan tegangan getaran torsional dilakukan untuk mengetahui tingkat stress poros yang diakibatkan oleh dampak dari getaran torsional pada sistem propulsi. pada pengecekan standar stress getaran torsional mengacu pada BKI Vol. III (Machinery Instalation).

Dari hasil perhitungan yang dilakukan sebelumnya yang mengacu pada persamaan yang terdapat pada BKI, didapatkan nilai dari tegangan getaran torsional pada kondisi operasi secara kontinyu sebesar $19,399 \text{ N/mm}^2$ dan nilai dari tegangan torsional pada kondisi operasi sementara sebesar $34,861 \text{ N/mm}^2$

Gambar 4.7 Nilai Ambang Batas Tegangan pada Poros Akibat Getaran Torsional



Speed Ratio —————

Hasil perhitungan τ_1 —————

Hasil perhitungan τ_2 —————

Dari hasil tersebut didapatkan bahwa nilai dari torsional stress pada *shaft propeller* kapal KMP. Dharma Rucitra masih memenuhi standar yang berlaku, karena masih didalam batas nilai yang diizinkan.

4.6 PENGURANGAN TINGKAT GETARAN

Berdasarkan pada analisa data yang telah dilakukan melalui perhitungan secara manual dan pengukuran secara langsung didapatkan bahwa nilai tingkat getaran pada kapal yang bersangkutan hampir dari segala aspek masih memenuhi standar dan peraturan yang berlaku, kecuali tingkat kenyamanan pekerja.

Berikut saran yang dapat dilakukan atau dipertimbangkan apabila kedepannya dalam proses perhitungan dan pengukuran tingkat getaran tidak memenuhi standar yang berlaku.

1. Menggunakan *tube in* (selongsong) pada poros untuk merukdiksi tingkat getaran torsional pada poros akibat putaran poros.
2. Menggunakan peremdaman kental (*viscous damper*) yang berupa cicin inersia yang ditambahkan pada *crankshaft* tertutup dalam lapisan cairan yang sangat kental seperti silikon. Dimana cairan tersebut akan mengurangi efek getaran secara radial akibat getaran yang ditumbuhkan oleh berputarnya *crankshaft*.
3. Menggunakan *Engine Struts* atau *Bracing*.



Gambar 4.8 Engine Struts

Sebuah peredam getaran yang menghubungkan antara objek yang akan direduksi tingkat getarannya

dengan struktur bagian kapal. Yang bertujuan untuk menghambat dan mengirim getaran yang terjadi pada objek yang diredam ke lambung kapal atau struktur kapal.

4.7 PENGURANGAN TINGKAT TEGANGAN GETARAN TORSIONAL.

Berdasarkan analisa data yang telah dilakukan melalui perhitungan manual berdasarkan standar BKI (Biro Klasifikasi Indonesia) didapatkan bahwa tingkat tegangan getaran torsional pada poros pada kapal yang bersangkutan masih memenuhi standar.

Berikut saran yang dapat dilakukan dipertimbangkan apabila kedepannya pada saat proses pengukuran atau perhitungan terhadap tingkat tegangan getaran torsional pada poros tidak memenuhi.

1. Tingkat kekerasan material sangat mempengaruhi tingkat *fatigue* pada poros. Sehingga semakin besar tingkat kekerasan material makin semakin rendah kemungkinan terjadinya *fatigue* pada poros. Apabila sebuah poros mengalami *fatigue*, maka tingkat kekerasan poros akan menurun sehingga poros dapat mengalami *bending*.
2. Apabila poros telah mengalami *bending* atau kelengkungan ada cara yang dapat dilakukan yaitu dengan membubutnya. Namun proses pembubutan akan menyebabkan diameter poros akan mengalami pengurangan. Dimana semakin kecil diameter sebuah poros maka kemungkinan terjadinya *fatigue* semakin besar. Oleh sebab itu maka dapat dilakukan penambalan poros untuk meningkatkan diameter sebuah poros.

“Halaman Ini Sengaja Dikosongkan”



GUIDANCE NOTES ON

SHIP VIBRATION

APRIL 2006 (Updated January 2015 – see next page)

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Foreword

The American Bureau of Shipping recognizes the overall ship vibration as an important measure to ensure the habitability, safety and functionality of the vessels. The *ABS Guidance Notes on Ship Vibration* have been developed to provide users with specific guidance on the design, analysis, measurement procedures and criteria in order to achieve the goal of limiting the ship vibration to an acceptable level. In the text herein, this document is referred to as “these Guidance Notes”.

The design and construction of the hull, superstructure, and deckhouse of a steel vessel are to be based on all applicable requirements of the *ABS Rules for Building and Classing Steel Vessels (Steel Vessel Rules 2006)*. Specifically, for the Container Carriers over 130 meters in length, the *ABS Steel Vessel Rules* require the consideration of vibratory responses of hull structures, as applicable (5-5-3/13.1). For the LNG Carriers, the *ABS Steel Vessel Rules* require special attention to the possible collapse of membrane due to hull vibration (5-8-4/4.2). In conjunction with the propulsion shaft alignment, the *ABS Steel Vessel Rules* require the consideration of propulsion shaft vibrations (4-3-2/7). For the cargo and passenger vessels, ABS provides optional classification notations for crew habitability and passenger comfort (*ABS Guide for Passenger Comfort on Ships* and *Guide for Crew Habitability on Ships*). Also ABS provides Condition Monitoring Program for machinery vibration (7-A-14/5.1.2 of the *ABS Rules for Survey After Construction (Part 7)*).

These Guidance Notes provide practical guidelines on the concept design to assist ship designers to avoid excessive shipboard vibration at an early design stage. These Guidance Notes also assist with the finite element analysis (FEA) based vibration analysis procedure to calculate the vibration response and evaluate the design at detail design stage. The analysis procedure represents the current analysis practice in ABS. These Guidance Notes also offer guidelines on the vibration measurement procedure at sea trials and the acceptance criteria on vibration limits based on the international standards and the practice in ABS.

These Guidance Notes are issued in 2006. Users of these Guidance Notes are welcome to contact ABS with questions or comments concerning these Guidance Notes. Users are advised to check periodically with ABS to ensure that this version of these Guidance Notes is current.



GUIDANCE NOTES ON SHIP VIBRATION

CONTENTS

SECTION 1	General	1
1	Introduction	1
3	Application.....	1
5	Scope	1
	FIGURE 1 Overall Procedure for Ship Vibration Assessment.....	2
SECTION 2	Concept Design	3
1	Introduction	3
3	Design Considerations.....	3
5	Concept Design Approach	4
	FIGURE 1 Items to be Considered During Concept Design	5
SECTION 3	Excitations	6
1	Introduction	6
3	Low-speed Main Diesel Engine	6
5	Hull Wake.....	8
5.1	Hull-Propeller Clearance.....	11
7	Propeller.....	13
7.1	Alternating Thrust	13
7.3	Hull Pressure Forces	17
	TABLE 1.....	8
	FIGURE 1 External Forces and Moments	6
	FIGURE 2 Guide Force Couples	7
	FIGURE 3 Nominal Wake Distribution for a Typical Merchant Ship (DTMB Model 4370, $C_B = 0.6$)	9
	FIGURE 4 Alternative Shafting Arrangements: Open Strut Stern (upper); Conventional Skeg Stern (lower).....	10
	FIGURE 5 Open Strut Stern Arrangement	12
	FIGURE 6 Conventional Skeg-Stern Arrangement	12
	FIGURE 7 Maximum Skew Angle	13
	FIGURE 8 Burrill Cavitation Inception Chart	16

SECTION 4	Structural Resonances	19
1	Introduction	19
3	Hull Girder Vertical Vibration Excited by the Main Diesel Engine.....	19
5	Main Machinery/Shafting System Longitudinal Vibration Excited by the Propeller	22
7	Superstructure Fore-and-Aft Vibration Excited	26
TABLE 1	Comparison of 2-node Vertical Vibration Natural Frequencies	20
TABLE 2	Flexible Base Correction Factors.....	27
FIGURE 1	Natural Frequencies of Vertical Hull Vibration	21
FIGURE 2	3-mass Longitudinal Model of Main Propulsion System.....	23
FIGURE 3	Example of Natural Frequencies vs. Foundation Stiffness	25
FIGURE 4	Deckhouse Types	27
FIGURE 5	Fixed-base Superstructure Natural Frequencies	27
FIGURE 6	Deckhouse Stiffening	29
SECTION 5	Vibration Analysis	31
1	Introduction	31
1.1	Scope and Objective	31
1.3	Procedure Outline of Ship Vibration Analysis	32
3	Finite Element Modeling	32
3.1	Global Model	32
3.3	Engine, Propeller Shaft and Stern/Skeg	33
3.5	Lightship Weight Distribution	35
3.7	Cargo, Water Ballast in Tanks and Fuel Oil in Tanks	35
3.9	Local Models	35
5	Loading Condition	35
5.1	Selection of Loading Conditions and Ship Speed.....	35
5.3	Added Mass	36
5.5	Buoyancy Springs	36
5.7	Special Conditions.....	36
7	Free Vibration	36
7.1	Analysis Procedure	36
7.3	Checking Points	38
9	Propeller Excitation	38
9.1	Introduction.....	38
9.3	Propeller Shaft Forces.....	38
9.5	Hull Surface Forces Induced by Propeller Cavitation	39
9.7	Direct Calculation of Bearing and Surface Forces	43
11	Engine Excitation	44
13	Forced Vibration.....	44
13.1	General.....	44
13.3	Critical Areas	45
13.5	Damping	45

TABLE 1	Propeller Bearing Forces and Moments for 20 Real Ship Case Study.....	39
FIGURE 1	Procedure to Perform Ship Vibration Analysis.....	32
FIGURE 2	Global FE Model Example	33
FIGURE 3	Engine Model Example	34
FIGURE 4	Turbine Engine and Propeller Shaft Modeling Example.....	34
FIGURE 5	Propeller Shaft	35
FIGURE 6	First Two Vertical Mode Shapes	37
FIGURE 7	First Two Horizontal Mode Shapes.....	37
FIGURE 8	Scale Effect due to Propeller Inflow Condition.....	43
SECTION 6	Measurements	46
1	General	46
1.1	Scope	46
1.3	Application	46
1.5	Terminology.....	46
3	Instrumentation	47
3.1	General Requirements.....	47
3.3	Calibration	47
5	Measurement Conditions	48
5.1	Environment Condition	48
5.3	Loading Condition.....	48
5.5	Course	48
5.7	Speed and Engine Power	49
7	Measurement Locations.....	49
7.1	Stern	49
7.3	Superstructure	49
7.5	Main Engine and Thrust Bearing	49
7.7	Lateral Shaft Vibration	50
7.9	Torsional Shaft Vibration	50
7.11	Local Structures.....	50
7.13	Local Deck Transverse	50
7.15	Local Machinery and Equipment	50
7.17	Shell Near Propeller.....	50
9	Data Processing Analysis	50
9.1	Measured Data	50
9.3	Performance of Measurements	51
9.5	Analysis Methods.....	51
11	Measurement Report	54
11.1	Analysis and Reporting of Data	54
TABLE 1	Typical Frequencies Ranges	51
TABLE 2	Examples of Alternate Vibration Measurements.....	53

SECTION 7	Acceptance Criteria.....	56
1	General	56
3	Vibration Limits for Crew and Passengers.....	56
3.1	ABS Criteria for Crew Habitability and Passenger Comfort	56
3.3	ISO 6954 (1984) Criteria for Crew and Passenger Relating to Mechanical Vibration	57
3.5	ISO 6954 (2000) Criteria for Crew and Passenger Relating to Mechanical Vibration	59
5	Vibration Limits for Local Structures	59
7	Vibration Limits for Machinery	60
7.1	Main Propulsion Machinery	60
7.3	Machinery and Equipment.....	61
TABLE 1	Maximum Weighted RMS Acceleration Levels for Crew Habitability.....	57
TABLE 2	Maximum Weighted RMS Acceleration Levels for Passenger Comfort	57
TABLE 3	Overall Frequency-Weighted RMS Values (ISO 6954: 2000)	59
TABLE 4	Vibration Limits for Main Propulsion Machinery.....	61
FIGURE 1	ISO 6954 (1984).....	58
FIGURE 2	Vibration Limits for Local Structures	60
APPENDIX 1	References.....	62
1	General References.....	62
3	Concept Design	62
5	FE Analysis	63
7	Measurement	63
APPENDIX 2	Corrections	64
1	Corrective Investigations.....	64
3	General Approach.....	65
5	Hydrodynamic Modifications	65
7	Structural Modifications.....	67
9	Case Study	67
9.1	Determination of Model Constants	68
9.3	Structural Rectification Analysis	69
9.5	Propeller Change	71
FIGURE 1	Wake Improvement with Special Lines-adapting Stern Devices Conventional Stern Cargo Ship	66
FIGURE 2	Mass-elastic Model of Deckhouse and Support Structure.....	68
FIGURE 3	Equivalent One-mass System.....	70

APPENDIX 3	Seaway Excitation and Response.....	73
1	General	73
3	Springing.....	73
5	Bow Flare Slamming and Whipping.....	73
7	Bottom Impact Slamming.....	74
APPENDIX 4	Concept Design Checklist	75



SECTION 1 General

1 Introduction

With the increase of ship size and speed, shipboard vibration becomes a great concern in the design and construction of the vessels. Excessive ship vibration is to be avoided for passenger comfort and crew habitability. In addition to undesired effects on humans, excessive ship vibration may result in the fatigue failure of local structural members or malfunction of machinery and equipment.

These Guidance Notes are to provide users, specifically shipyards, naval architects, and ship owners, with practical guidance on the concept design to avoid excessive ship vibration at an early design stage. If simple procedures are followed with insight and good judgment in the concept design stage, then the difficult countermeasures and corrections at the subsequent design stages may be avoided in most cases.

These Guidance Notes also assist with the finite element analysis (FEA) based vibration analysis procedure to predict the vibration response and evaluate the design in detail design stage. The vibration analysis procedure represents the most current analysis practice in ABS. These Guidance Notes also offer guidelines on the vibration measurement procedure during the sea trials and the acceptance criteria on vibration limits based on international standards and practice in ABS.

3 Application

These Guidance Notes are applicable to the vessels of all lengths.

5 Scope

These Guidance Notes provide overall guidelines on ship vibration excited by the main engine and propeller. In these Guidance Notes, the following subjects are considered:

- i) Concept Design
- ii) Vibration Analysis
- iii) Measurements
- iv) Acceptance Criteria

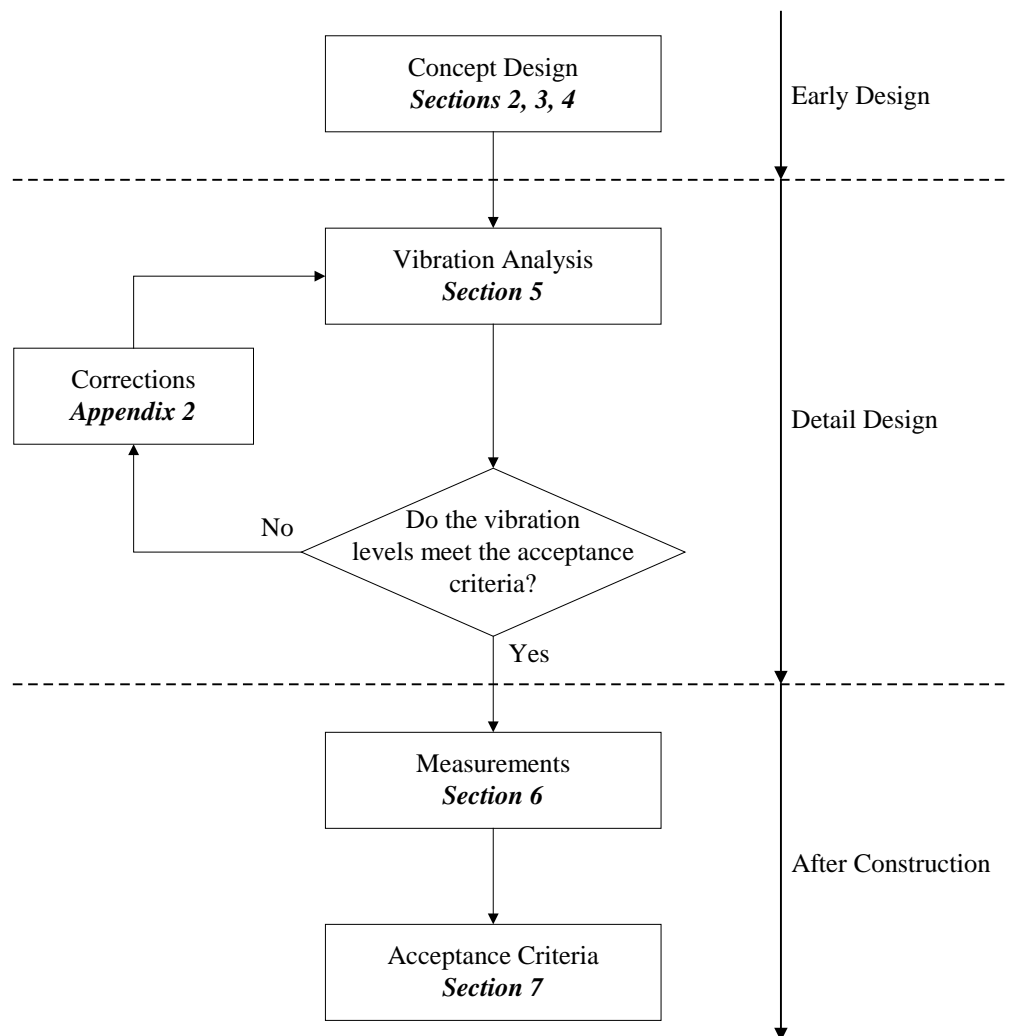
The concept design in Sections 2, 3 and 4 provides users with immediate, direct, and concise guidance in effectively dealing with ship vibration in the *concept design* stage. In attempting to provide a sound and no-nonsense guidelines, these Guidance Notes identify the most serious problem areas that have caused difficulties to the industry, and concentrate on those areas. In the concept design, local vibration is not addressed because detail information is not usually available in the early design stage. Instead, the concept design is focused on those areas that have been known to be of critical importance in avoiding harmful ship vibration.

The vibration analysis in Section 5 provides the FE-based vibration analysis procedure based on first principles direct calculations. The FE-based vibration analysis is recommended to evaluate the design during the detail design stage. If found necessary, the local vibration is to be addressed in the detail vibration analysis. The analysis procedure provides guidelines on FE modeling, engine and propeller excitation, and free and forced vibration analysis.

For the assessment of ship vibration performance, the actual vibration levels at the most critical locations are to be measured and evaluated during the sea trials. Section 6 provides guidelines on the vibration measurement procedure on the instrumentation, measurement conditions and locations, data processing and reporting. Section 7 provides acceptance criteria on the vibration limits for human comfort and habitability, local structures and machinery based on international standards and practice in ABS.

The shaft alignment and torsional vibration are not directly addressed in this document. For the requirements of the shaft alignment and torsional vibratory stress, refer to 4-3-2/7 of the *ABS Steel Vessel Rules*. The overall procedure for ship vibration assessment recommended in these Guidance Notes is shown in Section 1, Figure 1.

FIGURE 1
Overall Procedure for Ship Vibration Assessment





SECTION 2 Concept Design

1 Introduction

Concept design is where the vibration avoidance process must begin. It is clear that if the vibration problems, repeatedly identified by experience as the most important, are addressed at the earliest design stage, ultimately serious problems, involving great cost in correction efforts, may be avoided.

The focus is on planning for vibration early at the *Concept Design* stage, where there has been no development of details. If as much as possible can be done in concept design with the simple tools and rules of thumb available at that level, it will help to avoid major vibration problems. The major potential problems may often be present in the crude concept design definition. Just identifying and addressing those potential problems in terms of the minimal technology available at the concept design stage is considered very important to the success of ship design.

Sections 2 through 4 provide guidelines on the concept design. Some of these guidelines are presented in *Principles of Naval Architecture, Chapter 7* (SNAME, 1988) and the SNAME granted permission to be included in this document.

3 Design Considerations

The four elements of importance in ship vibration are:

- Excitation,
- Stiffness,
- Frequency Ratio, and
- Damping

It is noted that any of the following contribute to vibration reduction:

- i) *Reduce exciting force amplitude, F .* In propeller-induced ship vibration, the excitation may be reduced by changing the propeller unsteady hydrodynamics. This may involve lines or clearance changes to reduce the non-uniformity of the wake inflow or may involve geometric changes to the propeller itself. Specifics in this regard are addressed in Section 3.
- ii) *Increase stiffness, K .* Stiffness is defined as spring force per unit deflection. In general, stiffness is to be increased rather than decreased when variations in natural frequency are to be accomplished by variations in stiffness. It is not a recommended practice to reduce system stiffness in attempts to reduce vibration.
- iii) *Avoid values of frequency ratio near unity; $\omega/\omega_n = 1$ is the resonant condition.* At resonance, the excitation is opposed only by damping. Note that ω/ω_n can be varied by varying either excitation frequency ω or natural frequency ω_n . The spectrum of ω can be changed by changing the RPM of a relevant rotating machinery source, or, in the case of propeller-induced vibration, by changing the propeller RPM or its number of blades. ω_n is changed by changes in system mass and/or stiffness; increasing stiffness is the usual and preferred approach. Specific measures for resonance avoidance in ships are addressed in Section 4.
- iv) *Increase damping, ζ .* Damping of structural systems in general, and of ships in particular, is small; $\zeta \ll 1$. Therefore, except very near resonance, the vibratory amplitude is approximately damping independent. Furthermore, damping is difficult to increase significantly in systems such as ships; ζ is, in general, the least effective of the four parameters available to the designer for implementing changes in ship vibratory characteristics.

5 Concept Design Approach

Four elements were identified in the preceding as being influential in determining ship vibratory response, and their relationship to vibration reduction was addressed. While quantification of all four elements is required in calculating the vibration response level, acceptable results may consistently be achieved with reasonable effort by focusing attention in concept design on two of the four elements. The two of the four elements of importance are *excitation* and *frequency ratio*. The achievement in design of two objectives with regard to these elements has resulted in many successful ships:

- Minimize dominant vibratory excitations, within the normal constraints imposed by other design variables, and
- Avoid resonances involving active participation of major subsystems in frequency ranges where the dominant excitations are strongest.

Unlike vibration response, the excitation and frequency ratio elements involved in these objectives may be predictable with useful reliability for making design judgments. For the most troublesome case of propeller excitation, detailed hydrodynamic calculation procedures in conjunction with model testing have been established, at least to the level of reliable relative predictions in the post-concept, preliminary design stage. Natural frequencies involving the ship hull and its major subsystems are usually predictable using judicious modeling and modern numerical structural analysis methods. Accuracy levels achievable in predictions of propeller and engine excitation and of sub-system natural frequencies are generally considered to be reliable to consistently achieve the two objectives cited above.

The detailed calculations and experiments required to avoid resonance and to minimize excitation are usually performed by engineering analysis groups or model basins, and are usually not the immediate responsibility of the ship designer. If addressed early enough while basic changes in a design can still be made, excessive vibration may be avoided effectively. The main functions of the ship designer in this regard are:

- To establish a concept design to serve as the subject of the detailed investigations,
- To judge whether detailed analysis is warranted as a further step.

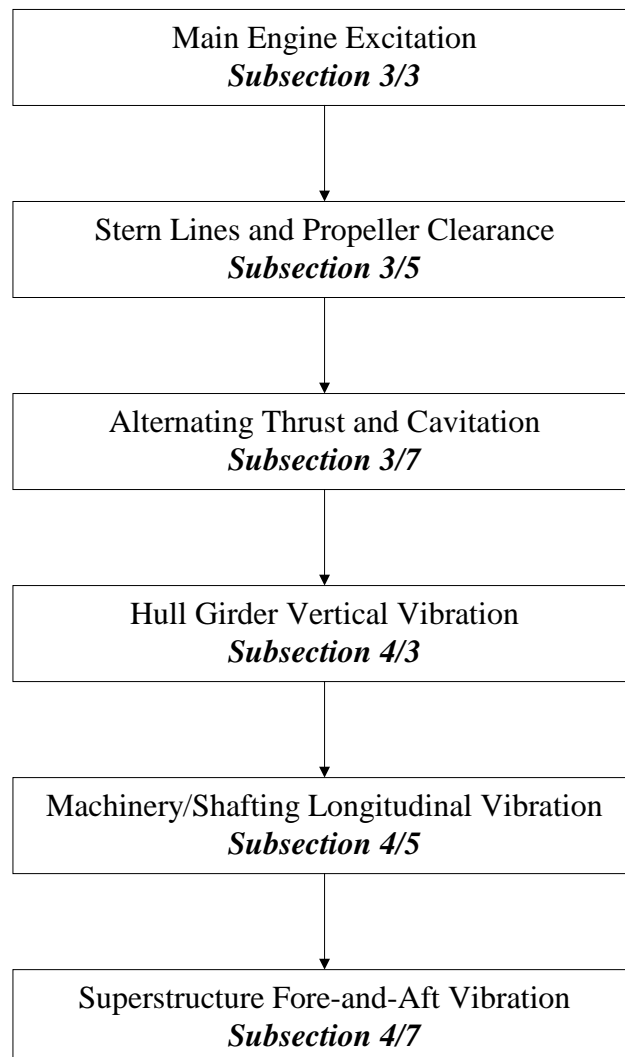
The quality of the concept design will be reflected in the number of detailed iterations, if any, that are required for achieving an acceptable final design. For the purpose of establishing high-quality concept designs, which may require time consuming calculations and model testing, the designer needs both guidance as to the areas of the design likely to be in most need of attention, and some simple methodology for identifying the critical aspects. Experience has shown that attention to vibration in concept design of large ships can usually be paid to the following items:

- i) Hull girder vertical vibration excited by the main engine.
- ii) Main machinery/shafting system longitudinal vibration excited by the propeller.
- iii) Superstructure fore-and-aft vibration excited by hull girder vertical vibration and/or main propulsion machinery/shafting system longitudinal vibration.

A myriad of local vibrations, such as hand-rails, antennas, plating panels, etc., may be encountered on new vessel trials in addition to these three. But local problems usually involve local structural resonances and often considered as minor problems, as the correction approach by local stiffening may be easily achievable.

Section 3 and Section 4 provide general guidance on the methodology of established effectiveness in dealing with the three critical items cited above in the concept design stage. Section 2, Figure 1 shows the important areas to be considered during concept design. The concept design checklist is summarized in Appendix 4.

FIGURE 1
Items to be Considered During Concept Design



SECTION 3 Excitations

1 Introduction

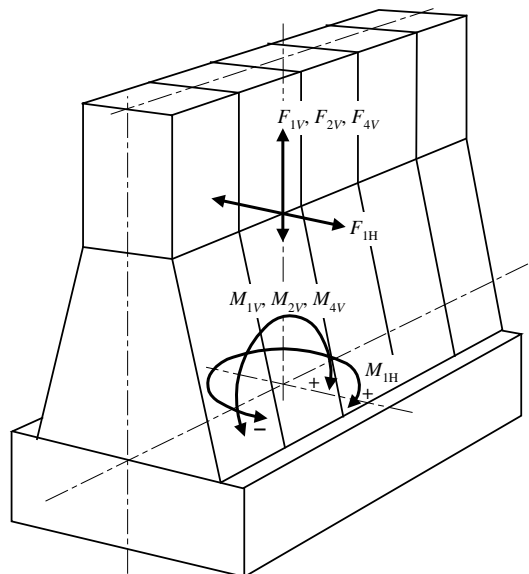
It is appropriate that the principal vibration exciting sources be addressed first, since with high excitation levels excessive vibration can occur almost independently of system structural characteristics. In general, the major sources are the low-speed diesel main engine and the propeller. Gas turbines are generally considered to give less excitation than diesel engines. Thus, in this section, attention is paid to the excitation of the low-speed main diesel engine.

3 Low-speed Main Diesel Engine

Significant progress has been made in recent years by engine manufacturers in reducing vibratory excitation, largely by moment compensators installed with the engine. Steps to be taken by the engine manufacturer are to be addressed in main engine specifications for a new vessel. In this regard, it is important for the shipyard or owner to be technically knowledgeable on this issue. Diesel engine vibratory excitation can be considered as composed of three periodic force components and three periodic moment components acting on the engine foundation. Actually, the periodic force component along the axis of the engine is inherently zero, and some other components usually balance to zero depending on particular engine characteristics.

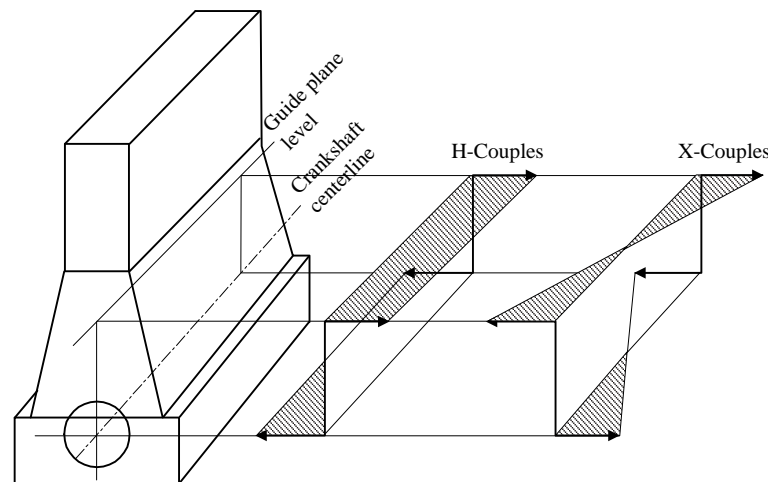
Two distinctly different types of forces can be associated with the internal combustion reciprocating engine. These are: (a) gas pressure forces due to the combustion processes (guide force couples) and (b) inertia forces produced by the accelerations of the reciprocating and rotating engine parts (external forces). Section 3, Figure 1 shows the typical external force and moments acting on a diesel engine.

FIGURE 1
External Forces and Moments



Guide force couples acting on the crosshead result from transverse reaction forces depending on the number of cylinders and firing order. The guide force couples cause rocking (H-couples) and twisting (X-couples) of the engine, as shown in Section 3, Figure 2. The engine lateral vibration due to the guide force couples may cause resonance with the engine foundation structure. A possible solution at concept design stage may be a consideration of lateral stays (top bracings), connecting the engine's top structure to the ship hull.

FIGURE 2
Guide Force Couples



The vertical force and moment, which are of primary concern with regard to hull vibratory excitation, and the transverse force and moment as well, are due to unbalanced inertial effects. For engines of more than two cylinders, which is the case of interest with ships, the vertical and transverse inertia force components generally balance to zero at the engine foundation. This leaves the vertical and transverse moments about which to be concerned. The values of the moment amplitudes are usually tabulated in the manufacturer's specification for a particular engine.

The majority of low speed marine diesels currently in service have 6 cylinders or more. Therefore, the 2nd order vertical moment M_{2v} is generally considered to contribute the most to the hull vibration. However, depending on the specific number of cylinders, the first order or higher order moment can be as large as the second order moment. In that case, further consideration is to be given to the first or higher order moment.

A hull girder mode up to the third or fourth can have a natural frequency as high as the twice-per-revolution excitation of the 2nd order vertical moment. Hull girder modes higher than the first three or four have diminishing excitability and may be of less concern. The following steps are therefore recommended in concept design:

- i) The 2nd order vertical moment M_{2v} is the diesel engine excitation of most concern. The potential danger is in resonating one of the lower hull girder vertical modes with a large 2nd order vertical moment. The value of M_{2v} is to be requested from the potential main engine manufacturer, as early as possible.
- ii) Power Related Unbalance (PRU) values may be used to determine the acceptable level of M_{2v}

$$PRU = \frac{M_{2v} \text{ [N - m]}}{\text{EnginePower [kW]}}$$

TABLE 1

<i>PRU</i>	<i>Need for Compensator</i>
Below 120	Not likely
120-220	Likely
Over 220	Most likely

Further attention is recommended in cases where PRU exceeds 220 N-m/kW. The action recommended at the initial engine selection stage may be either change of engine selection or installation of moment compensators supplied by the engine manufacturer. Otherwise, the vertical hull girder response is to be checked by calculation within an acceptable level without installation of compensators.

- iii) The engine lateral vibration due to X-type and H-type moments may produce excessive local vibration in the engine room bottom structure depending on the engine frame stiffness and engine mounting. The installation of lateral stays on the engine room structure is to be addressed at the early design stage.

5 Hull Wake

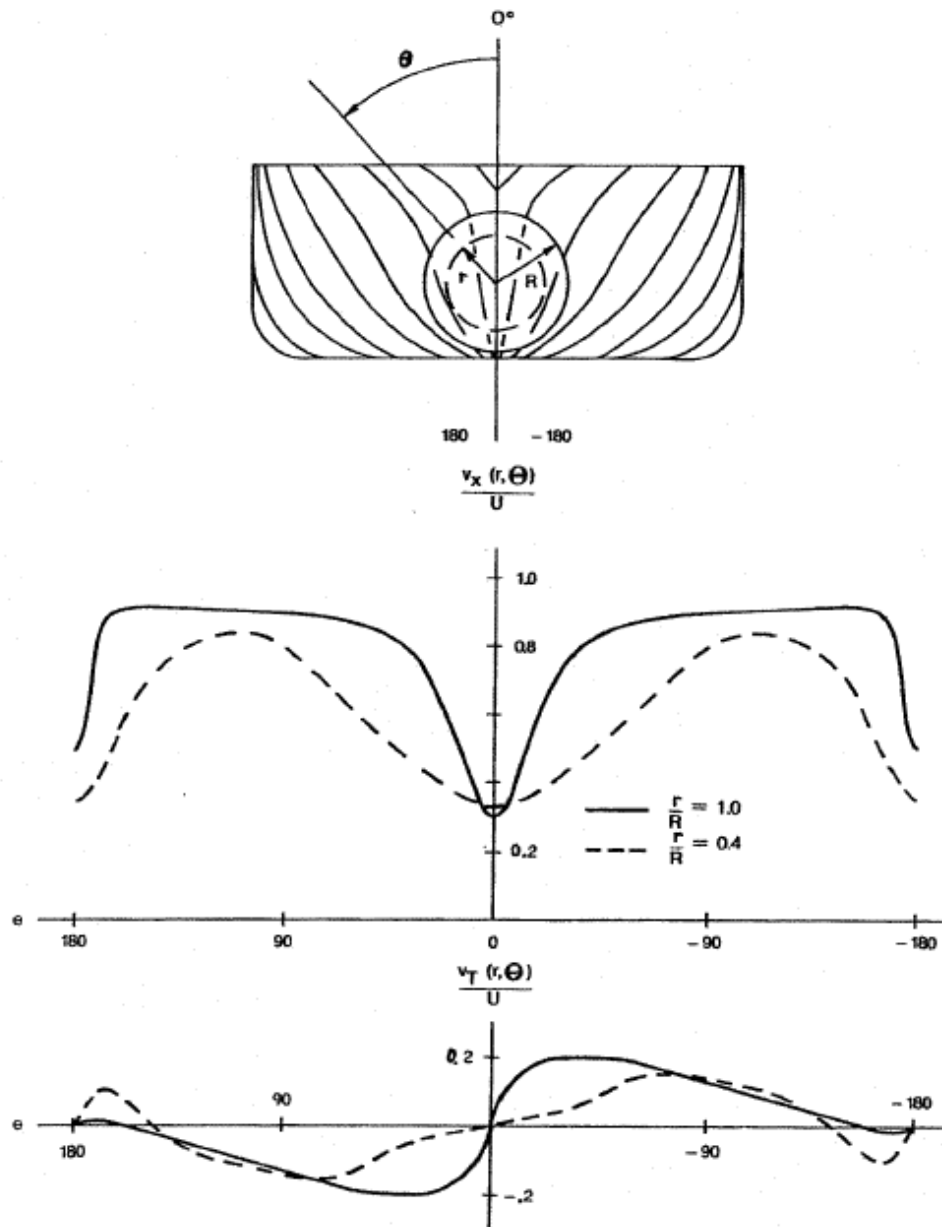
Hull wake is one of the most critical aspects in avoidance of unacceptable ship vibration. Propeller-induced vibration problems in general start with unfavorable hull lines in the stern aperture region, as manifest in the non-uniform wake in which the propeller must operate. Unfortunately, propeller excitation is far more difficult to quantify than the excitation from internal machinery sources. This is because of the complexity of the unsteady hydrodynamics of the propeller operating in the non-uniform hull wake. In fact, the non-uniform hull wake is the most complicated part; it is unfortunate that it is also the most important part. Propeller-induced vibration would not be a consideration in ship design if the propeller disk inflow were circumferentially uniform. Any treatment of propeller excitation must begin with a consideration of the hull wake.

For engineering simplification, the basic concepts allow for the circumferential non-uniformity of hull wakes, but assume, for steady operation, that wake is time invariant in a ship-fixed coordinate system. Nominal wake data from model scale measurements in towing tanks are presented either as contour plots or as curves of velocity versus angular position at different radii in the propeller disc. Section 3, Figure 3 shows the axial and tangential velocity components for a typical conventional stern merchant ship.

The position angle, θ , on Section 3, Figure 3 is taken as positive counterclockwise, looking forward, and x is positive aft. The axial wake velocity v_x and tangential wake velocity v_T are dimensionless on ship forward speed, U . Note that the axial velocity is symmetric in θ about top-dead-center (even function) and the tangential velocity is asymmetric (odd function). This is a characteristic of single screw ships due to the transverse symmetry of the hull relative to the propeller disk; such symmetry in the wake does not, of course, exist with twin-screw ships.

The wake illustrated above represents one of the two characteristically different types of ship wakes. The flow character of the conventional skeg-stern is basically waterline flow; the streamlines are more or less horizontal along the skeg and into the propeller disk. The flow components along the steep buttock lines forward of the propeller disk are small. The dominant axial velocity field of the resultant wake has a substantial defect running vertically through the disk along its vertical centerline, at all radii.

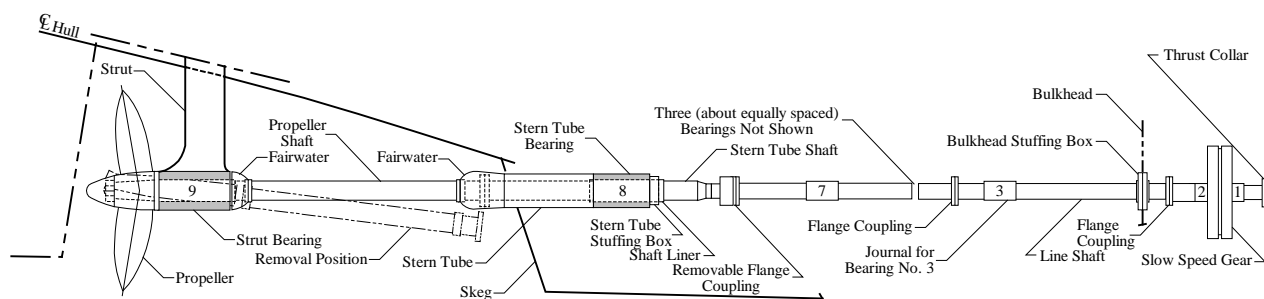
FIGURE 3
Nominal Wake Distribution for a Typical Merchant Ship (DTMB Model 4370, $C_B = 0.6$)



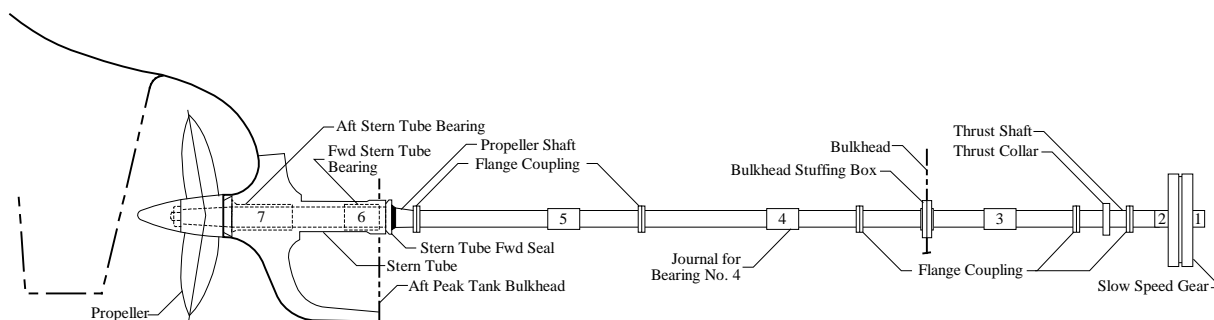
This defect is the shadow of the skeg immediately forward. The tangential flow in the propeller disk, being the combination of the component of the upward flow toward the free surface and any disk inclination relative to the baseline, is much smaller.

The idealization of this wake, for conceptual purpose, is the two-dimensional flow behind a deep vertical strut placed ahead of the propeller. In this idealization, the axial velocity distribution is invariant vertically, and any tangential velocity distribution (due to disk inclination) is asymmetric about the vertical disk axis. This basic characteristic is exhibited in the Section 3, Figure 3.

FIGURE 4
Alternative Shafting Arrangements:
Open Strut Stern (upper); Conventional Skeg Stern (lower)



Shafting Arrangement with Strut Bearing



Shafting Arrangement without Strut Bearing

A characteristically different wake flow is associated with the *strut or barge-type* stern, the upper of Section 3, Figure 4, which has a broad counter above the propeller disk and minimal irregularity immediately forward. The engine is further forward with this stern-type to accommodate finer stern lines needed to minimize wave resistance in high speed ships, although an open strut stern would be beneficial for vibration minimization at any speed (provided the buttocks lines are not too steep). The flow character over this type of stern is basically along the buttock lines, versus the waterlines. Some wake non-uniformity may be produced by appendages forward, such as struts and bearings or by shaft inclination, but the main wake defect, depending on the relative disk position, will be that of the counter boundary layer overhead. In this case, assuming minimal shaft inclination, substantial axial wake again exists, but only in the top of the disk. Generally, only the blade tips penetrate the overhead boundary layer, and the axial wake defect occurs only at the extreme radii near top-dead-center, rather than at all radii along the vertical centerline, as in the case of the conventional single screw stern. Just as in the case of the conventional stern, the tangential disk velocity with the strut stern will generally be small; the vertically upward velocity ratio through the propeller disk will have average values on the order of the tangent of the sum of the buttock and shaft inclination angles. The idealization in the case of the barge stern, as a sequel to the vertical strut idealization of the wake of the conventional stern, is a horizontal flat plate above the propeller. Here, the degree of axial wake non-uniformity depends on the overlap between the propeller disk and the plate boundary layer. The tangential (and radial) wake components are due entirely to the shaft relative inclination angle in this idealization, as the flat plate boundary layer produces only an axial defect.

5.1 Hull-Propeller Clearance

The distinction between the two basically different wake types is useful in understanding the importance of clearances between the propeller blades and local hull surfaces. First of all, it is helpful to consider the hull surface excitation by the propeller as composed of two effects:

- i) *Wake effect.* The effect of changing the wake inflow to the propeller according to a specified propeller relocation, but with the propeller actually fixed in position relative to the hull.
- ii) *Diffraction effect.* The effect of changing the propeller location relative to the hull, but with the wake inflow to the propeller held fixed.

It is a common misconception that the cruciality of propeller-hull clearances has to do primarily with the diffraction effect. To the contrary, analysis shows that for wake inflow held invariant, propeller-induced excitation level is relatively insensitive to near-field variations in propeller location. It is the high sensitivity of propeller blade pressure and cavitation inception to the variations in wake non-uniformity accompanying clearance changes that dictates the need for clearance minima. In general, the wake gradients become more extreme as propeller-hull clearances are decreased.

The conventional and strut-stern wake types are to be considered in light of the above fact. It is probable that too much emphasis is often placed on aperture clearances in conventional stern single-screw ships. From the point of view of vertical clearance, there is no significant boundary layer on the usually narrow counter above the propeller with this stern type. Furthermore, from the point of view of the vertical strut idealization of the skeg, the axial velocity distribution would be invariant with vertical disk position. The critical item with vertical tip clearance in the conventional stern case seems to be the waterline slope in the upper skeg region. Blunt waterline endings can result in local separation and substantially more severe wake gradients in the upper disk than suggested by the simple strut idealization; a “blunt strut” idealization then would be more appropriate. Fore-and-aft clearances in the conventional stern case are generally less critical than the vertical clearances. Wakes attenuate very slowly with distance downstream. While increasing the fore-and-aft clearances between the blade tips and the skeg edge forward certainly acts to reduce the wake severity, the reduction will be marginally detectable within the usual limits of such clearance variation. An exception would exist in the case of separation in the upper disk due to local waterline bluntness. The closure region of the separation cavity in that case exhibits large gradients in axial velocity.

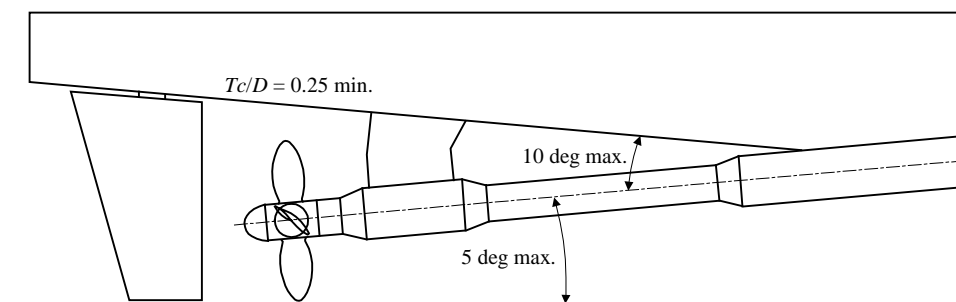
On the other hand, for the broad and flat countered strut stern vessel, the vertical tip clearance is a much more critical consideration. A relatively uniform wake will result if the propeller disk does not overlap the overhead boundary layer and the shaft inclination is moderate. This is the condition, in general, achieved on naval combatant vessels; the usual practice in naval design is a minimum vertical tip clearance of one-quarter propeller diameter. Vibration problems are almost unheard of on naval combatants.

Some wake non-uniformity on strut stern ships results from shaft struts and from the relatively high shaft inclinations often required to maintain the 25 percent overhead tip clearances. With proper alignment to the flow, shaft struts produce highly localized irregularities in the wake which are generally not effective in the production of vibratory excitation. The main effect of shaft inclination is a relative up-flow through the propeller disk, although separated flow from forward off of a highly inclined propeller shaft can produce a serious axial defect. The cavitation that can result at the 3 and 9 o'clock blade positions has shown to be of concern with regard to noise and minor blade erosion, but the hull vibratory excitation produced has not been found to be of much significance for strut stern ships.

The minimum vertical tip clearance of 25 percent of a propeller diameter is more or less accepted as the standard in commercial practice as well as naval. Consistent with the preceding analysis, the following lists the recommended configuration for stern arrangements in the order of preference for avoidance of excessive propeller induced vibration:

- i) *Single/Twin Screw Strut Stern*
 - The minimum vertical tip clearance is not to be less than 25% of the propeller diameter.
 - The shaft inclination angle relative to the baseline is not to be more than 5 degrees.
 - The shaft inclination angle relative to the buttocks angle of the counter is not to be more than 10 degrees. Refer to Section 3, Figure 5.

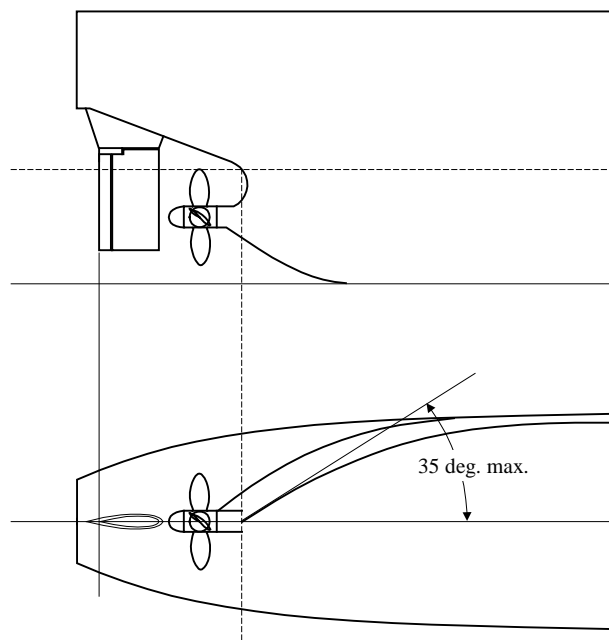
FIGURE 5
Open Strut Stern Arrangement



ii) *Conventional Stern with Skeg and Bossing.*

- The waterline angle from the vertical centerplane at the entrance to the aperture just forward of the top of the propeller disk is not to exceed 35 degrees. Refer to Section 3, Figure 6.

FIGURE 6
Conventional Skeg-Stern Arrangement



- With regard to the propeller tip clearance, the conventional skeg-stern ships are less critical than the strut-stern ships, as discussed earlier. In commercial practice, a minimum vertical tip clearance on order of 25% of propeller diameter and forward clearance of 40% of propeller diameter are often employed as a usual practice.
- iii) In the event that these limits cannot be achieved in concept design, it is recommended that the decision be made to proceed on to model testing and/or direct calculation for confirming or establishing stern lines.

7 Propeller

With an unfavorable wake, propeller compromises are then usually required to achieve compensation. Two types of excitation are of primary concern in conjunction with the three main items identified as critical in Subsection 2/5.

- i) Alternating thrust exciting longitudinal vibration of the shafting and machinery, and
- ii) Vertical pressure forces on the stern counter exciting hull and superstructure vibration.

7.1 Alternating Thrust

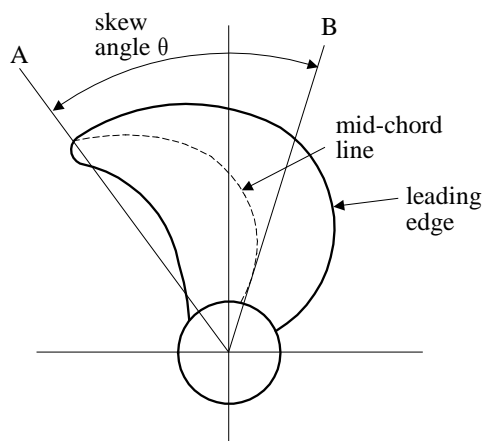
Alternating thrust, the excitation for longitudinal vibration of the shafting/main machinery system, occurs at blade rate frequency (Propeller RPM \times Blade number N) and its multiples. The fundamental is usually much larger than any of its harmonics, however. Alternating thrust is produced by the blade number circumferential harmonic of the hull wake. This suggests that the higher the blade number the better, since the wake harmonic series does converge. However, around the typical blade number of 4, 5, and 6, the wake harmonic series convergence is not well organized, and is not a primary consideration. In fact, with the wake of a conventional single-screw stern, lower alternating thrust favors an odd-bladed propeller. This is because of, for an even bladed propeller, the line-up of opposite blades with the characteristic wake spike along the vertical center-plane above and below the propeller axis. This wake characteristic was discussed in Subsection 3/5 on hull wake. With strut-stern ships there is typically little blade number bias on the basis of wake.

Misconceptions exist about the effectiveness of propeller blade “skew” in reducing vibratory excitation. Skew is the tangential “wrapping” of the blades with radius. Positive skew is in the angular direction opposite to the direction of rotation. For the case of the conventional single screw ship wake, it has been discussed that the shadow of the vessel skeg produces a heavy axial wake defect concentrated along the disk vertical centerline. The blades of conventional propellers ray-out from the hub (i.e., the blade mid-chord lines are more or less straight rays emanating from the hub centerline). Such “unskewed” blades abruptly encounter the axial velocity defect of the conventional stern wake at the top and bottom-dead-center blade positions. The radially *in-phase* character of the abrupt encounter results in high net blade loads and radiated pressure.

A more gradual progression of the blades through the vertical wake defect is accomplished by curving the blades. Different radii enter and leave the wake spike at different times; cancellation results in the radial integrations to blade loads and radiated pressure, with the result of potentially significantly reduced vibratory excitation.

Percentage skew is the blade tip skew angle, relative to the blade ray through the mid-chord of the propeller hub section, divided by the blade spacing angle (e.g., for 5 blades the blade spacing angle is 72 degrees; therefore, a tip skew angle of 72 degrees would be 100% skew). See Section 3, Figure 7, where ray ‘A’ is passing through the tip of blade at mid-chord line and ray ‘B’ is tangent to the mid-chord line on the projected blade outline.

FIGURE 7
Maximum Skew Angle



Highly skewed propellers may be designed to have efficiency equivalent to propellers with minimal skew, but there have been problems with blade strength and flexibility. The modern trend has been a movement back toward more moderate positive tip skew, but with negative skew in the blade root regions. Here the percent skew may be defined in terms the total angle enclosed by the angular maxima of the blade leading and trailing edges. This provides blades with more balanced skew distributions, and highly *swept* leading edges. The radial load cancellations are achieved as effectively and blade strength is less problematic. The balanced skew is beneficial to limiting blade spindle torque with controllable pitch propellers, and is used widely with naval combatant vessels.

Skew will inherently work less effectively with strut-stern wakes since the axial velocity defect tends to be concentrated more in the outer extreme radii. The more radially uniform distributions of the conventional stern case are not available with which to achieve as high a degree of *dephasing* and radial cancellation. Of course, the strut stern vessel is in less need of propeller design extremes, as vibration problems are already largely eliminated by the stern form selection, provided proper clearances are incorporated.

Care must be taken in incorporating skew, particularly in replacement propellers, that adequate clearances between the blade tips and the rudder be maintained. As the blades are skewed in the pitch helix the tips move downstream, closing-up blade tip to rudder clearances. The consequences can be increased hull vibratory forces transmitted through the rudder, as well as rudder erosion caused by the collapsing sheet cavitation shed downstream off the blade tips as they sweep through the top of the propeller disk. The recourse is to incorporate warp into the blades along with the skew. Warping is a forward raking of the skewed blades back to (and sometimes beyond) the propeller disk. It is equivalent to skewing the blades in the plane of the disk rather than in the pitch helix.

It is noted that skew (and/or sweep) has a beneficial effect in reducing the effects of vibration-producing unsteady sheet cavitation, even when such cavitation may be concentrated in the blade tips. The blade curvature is thought to result in a radially outward flow component in the vicinity of the blade tips which tends to sweep the cavity sheets into the tip vortex, where the critical collapse phase occurs more gradually. Unsteady sheet cavitation is found to have minimal effect on alternating thrust, but can dramatically amplify the hull pressure force components. This is addressed specifically in 3/7.3.

If the guidelines offered on stern lines with regard to hull wake are adopted, then moderate and acceptable alternating thrust will result with propellers properly sized for propulsion considerations. This is without the need, particularly at the concept design stage, for detailed analysis to quantify alternating thrust level further along. Such quantification for detailed analysis is considered in Section 5.

Some ranges of the blade-rate alternating thrust amplitude are given below to serve as a reference for engineering decision making at the concept design level. The values are given as percentages of steady ahead thrust, and *assume that due care has been taken with stern lines and that the propeller is properly sized for proper propulsive performance*:

	<i>Alt Thrust/Steady Thrust</i>
Conventional Stern, moderately skewed/swept	0.02-0.06
Strut Stern	0.005-0.03

More details on propeller bearing forces and moments including alternating thrust for 20 real ship cases are given in Section 5. There is an outstanding issue here regarding proper sizing of the propeller, which is needed in the trade-offs at the concept design level. The old Burrill (1943) cavitation criterion is still useful in this regard. As stated, alternating thrust is not very sensitive to blade cavitation, but limiting the steady cavitation to accepted levels assures that the propeller is not overloaded from propulsive considerations, which is recommended as necessary to achieve the alternating thrust ranges listed above.

The Burrill chart is Section 3, Figure 8, which is a plot of a thrust loading coefficient at the 0.7 propeller blade radius, τ_c , versus the blade cavitation number, σ , also at the 0.7 radius.

$$\tau_c = \frac{T}{A_p q_T} \quad \text{and} \quad \sigma = \frac{p_a + \rho g h - p_c}{q_T}$$

where

T	=	propeller thrust in kN
A_p	=	propeller projected area in m^2
q_T	=	$\frac{1}{2} \rho V_R^2$ in kPa
V_R	=	relative velocity of water at 0.7 radius in m/sec
p_a	=	absolute atmospheric pressure in kPa
h	=	depth of the propeller axis in m
p_c	=	cavitation cavity absolute pressure in kPa
ρ	=	water density in ton/m^3

The relative velocity V_R at 0.7 radius is:

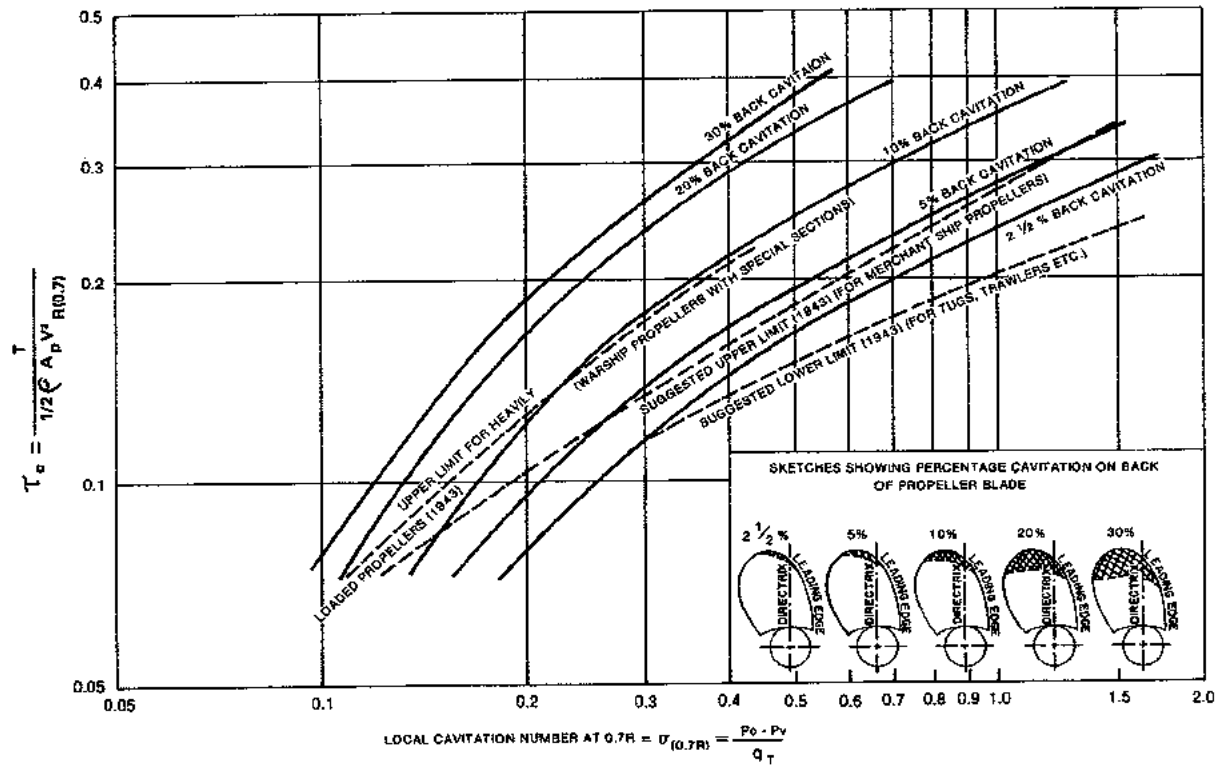
$$V_R(0.7R) = U(1 - w) \sqrt{1 + \left(\frac{0.7\pi}{J} \right)^2}$$

where

U	=	ship speed
w	=	wake fraction
J	=	design advance coefficient

The cavity pressure is often taken to be pure vapor pressure at the ambient water temperature, but for developed cavitation as is the case here, versus inception, p_c is higher due to dissolved air in the water; p_c around 6-7 kPa is often assumed. The curves of Section 3, Figure 8 correspond to the degree of steady cavitation development. The 5% back cavitation line was suggested as the limit for merchant ship propellers back in 1943. However, for modern commercial ship propellers, which are universally designed with aerofoil-type blade sections, the 10% back cavitation line is probably more appropriate. But either the 5% or 10% lines, considering the cavitation developments shown, may serve the purpose to avoid overloading the propeller in steady propulsion.

FIGURE 8
Burrill Cavitation Inception Chart



An example of the use of the Burrill chart for this purpose is as follows:

- Take a single screw ship with a delivered power $P_d = 22,380$ kW and a max rated speed $U = 22$ knots, corresponding to a thrust, $T = 1,400$ kN. The propeller diameter has been set at 6 meters consistent with tip clearance maxima. The $PRPM = 120$ and the wake fraction is estimated as $w = 0.2$. The pitch ratio at the 0.7 radius, $P/D]_{0.7R} = 0.9$. This gives an advance coefficient, $J = 0.755$ and resulting q_T of 399.3 kPa. For the hub centerline depth $h = 4.5$ m, $p_a = 101.3$ kPa, and $p_c = 6.9$ kPa, $\sigma = 0.35$. If the 5% back cavitation line is selected, $\tau_c \cong 0.16$. With the disk area $A_0 = \pi D^2/4$, the required projected area ratio would be:

$$\frac{A_p}{A_0} = \frac{4T}{\pi \tau_c q_T D^2}$$

- Substituting the values, $A_p/A_0 = 0.775$. It is preferable to work with the developed area ratio, A_d/A_0 , where A_d denotes propeller developed area with zero pitch. Taylor's approximate formula gives the projected area in terms of the developed area as:

$$\frac{A_p}{A_d} \cong 1.067 - 0.229 \frac{P}{D} \Big]_{0.7R}$$

Then the required developed area ratio is:

$$\frac{A_d}{A_0} = 0.90$$

- The projection here is then, with a good wake, as to be achieved by following the provided recommendations in these Guidance Notes, the subject propeller blades may not be heavily loaded in the mean, and the alternating thrust is to be in approximately direct proportion. As an alternative, if it was decided to use a less conservative approach and accept steady cavitation to the 10% back cavitation at $\sigma = 0.35$, $\tau_c \cong 0.2$. Then the alternative developed area ratio would be:

$$\frac{A_d}{A_0} = 0.72$$

Of course, the more conservative propeller, with the larger blades, will have lower propulsive efficiency. The following is recommended in concept design, in addition to the preceding stern lines recommendations relative to hull wake, for achieving not excessive alternating thrust from the propeller design consideration:

- i) Perform the Burrill cavitation calculation demonstrated above with a blade area ratio as needed to limit the steady cavitation up to 10% back cavitation.
- ii) For a conventional stern, a 5-bladed propeller is favored in reducing the alternating thrust, unless any harmful resonant vibration is anticipated on superstructure, shafting system or local structures.
- iii) In general, incorporate blade skew of no more than 50%, or if a blade with a highly swept leading edge is adopted (negative skew in the root), use no more than 25 degrees of tip skew (for either stern type). For a highly skewed propeller design other than the foregoing, refer to 4-3-3/5.5 of the *ABS Steel Vessel Rules*.

7.3 Hull Pressure Forces

The dominating excitation for ship hull vibration, related to the third of the three critical items identified in the preceding, is propeller cavitation-induced hull surface pressure forces. If intermittent blade cavitation does not occur to a significant degree, then the main excitation of the hull is via the shafting system and the main engine, as already discussed. These sources will cause minor problems relative to, at times, the intense vibration from an intermittently cavitating propeller. It was in the mid-70's that propeller blade unsteady cavitation, triggered by the wake non-uniformity, was found to be the main culprit in most of the ship vibration troubles.

The sheet cavitation expands and collapses on the back of each blade in a repeating fashion, revolution after revolution. The sheet expansion typically commences as the blade enters the region of high wake in the top part of the propeller disk. Collapse occurs on leaving the high-wake region in a violent and unstable fashion, with the final remnants of the sheet typically trailed out behind in the blade tip vortex. The sheet may envelop almost the entire back of the outboard blade sections at its maximum extent. For large ship propellers, sheet average thicknesses are on the order of 10 cm, with maxima on the order of 25 cm occurring near the blade tip just before collapse.

The cavitation, while of catastrophic appearance, is usually not deleterious from the standpoint of ship propulsive performance. The blade continues to lift effectively; the blade suction-side surface pressure is maintained at the cavity pressure where cavitation occurs. The propeller bearing forces (i.e., alternating thrust) may be largely unaffected relative to non-cavitating values for the same reason. The cavitation may or may not be erosive, depending largely on the degree of *cloud cavitation* (a mist of small bubbles) accompanying the sheet dynamics. The devastating appearance of fluctuating sheet cavitation is manifest consistently mainly in the field pressure that it radiates, and the noise and vibration that it thereby produces. The level of hull surface excitation induced by a cavitating propeller can be easily an order of magnitude larger than typical non-cavitating levels. Vertical hull surface forces due to intermittent cavitation typically exceed propeller bearing forces by large amounts.

The cavitation-induced hull surface force is, like the bearing forces, composed of the fundamental blade-rate frequency and its harmonics. However, unlike the character of the alternating thrust discussed in the preceding, the harmonics of the cavitating surface force typically converge very slowly. The fundamental, at PRPM times blade number, is usually largest, but twice and three times blade-rate of the same order typically exists, and can resonate structure and generate noise well above the normal excitation frequency range.

Cavitating vibratory force reduction is achievable with propeller design refinements, as sheet cavitation dynamics is sensitive to blade geometric, as well as wake, detail. As previously noted, blade skew can be beneficial, and tip loading can be reduced to reduce cavitation extent and intermittency by local blade tip pitch reduction, as well as changes in blade tip chord distributions. But measures of this type do reduce propeller efficiency and thereby compromise propulsive performance.

The occurrence of propeller blade intermittent cavitation cannot be ignored in attempts to control propeller induced hull vibration. The issue here is again primarily a hull wake issue. With an unfavorable wake, characterized as exhibiting high gradients in the upper disk, or even a separation pocket, the resulting large cavity volume variations can produce hull surface force amplitudes of up to 30-40% of the steady thrust, with significant levels out to several harmonics of blade-rate frequency. But even with a good wake, as described in the preceding, the conventional stern ship will still exhibit a wake defect in the disk over the depth of the skeg, and some intermittent cavitation will be unavoidable. A vertical surface force with a blade-rate amplitude of 15% of steady thrust is probably a conservative reference for a conventional stern ship with a “good wake” as achievable by the stern lines guidance of the preceding section.

With strut stern vessels with ample tip clearances and low relative shaft inclination, intermittent cavitation, or any cavitation at all, might be avoided entirely. This is largely achieved in the case of radiated noise sensitive naval combatant vessels.

Prediction of the cavitating hull forces is much more complicated, with many more factors contributing, than is alternating thrust, which, as stated, is more or less insensitive to cavitation. Cavitating hull force analysis is certainly not an activity for concept design. However, with any conventional stern ship of modern power level, a propeller cavitation/hull pressure assessment program is to be initiated in the preliminary design stage. For the direct calculation of the propeller-induced hull surface force, refer to the vibration analysis procedure described in Section 5.

At concept design, which is the scope of interest here, the same analysis as in the preceding subsection, using the Burrill criteria for 5-10% steady back cavitation, is to be applied to provide reasonable protection against under-sizing the propeller blades from the standpoint of unsteady cavitation. The example of the preceding subsection on alternating thrust is therefore proposed as applicable here as well.

SECTION 4 Structural Resonances

1 Introduction

The three critical items in concept design are identified in Section 2. The relevant excitation having been treated in Section 3, the three items are addressed in this section, mainly focused on resonance avoidance.

3 Hull Girder Vertical Vibration Excited by the Main Diesel Engine

The vertical beam-like modes of vibration of the hull girders of modern ships may become serious in two respects:

- i) They can be excited to excessive levels by resonances with the dominant low frequency excitations of slow-running diesel main engines.
- ii) Vertical vibration of the hull girder in response to propeller excitation is a direct exciter of objectionable fore-and-aft superstructure vibration.

The propeller is generally incapable of exciting the hull girder modes themselves to dangerous levels. This is primarily because the higher hull girder modes whose natural frequencies fall in the range where propeller excitation is significant have low excitability. However, the low-level vertical hull girder vibration that does occur, either directly from the propeller or indirectly via the main shafting thrust bearing, serves as the base excitation for excessive vibration of superstructures and other attached subsystems which are in resonance with the propeller exciting frequencies. This will be addressed in a later section. The natural frequencies corresponding to the two-noded vertical bending modes of conventional ship hulls can be estimated with reasonable accuracy using Kumai's formula is:

$$N_{2v} = 3.07 \times 10^6 \sqrt{\frac{I_v}{\Delta_i L^3}} \text{ cpm}$$

where

- I_v = moment of inertia, in m^4
- Δ_i = virtual displacement, including added mass of water, in tons
- $= \left(1.2 + \frac{1}{3} \cdot \frac{B}{T_m} \right) \Delta$
- Δ = ship displacement, in tons
- L = length between perpendiculars, in m
- B = breadth amidships, in m
- T_m = mean draft, in m

TABLE 1
Comparison of 2-node Vertical Vibration Natural Frequencies

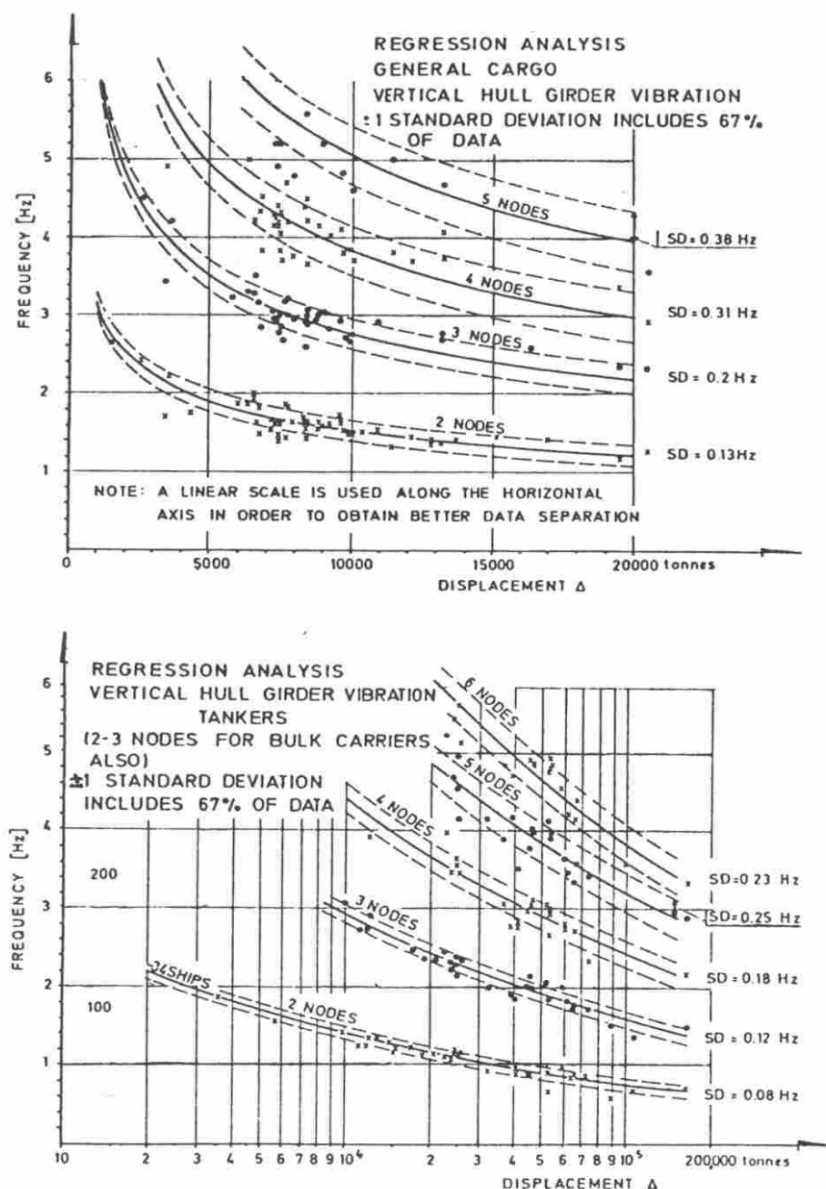
<i>Ship No.</i>	<i>Type</i>	<i>Size (tone)</i>	<i>Kumai (Hz)</i>	<i>FE Method (Hz)</i>	<i>Dev. (%)</i>
1	Reefer	15000	1.54	1.51	+2
2	Ro-Ro	49000	1.49	1.60	-7
3	Ro-Ro	42000	1.04	0.94	+10
4	Chemical	33000	1.00	0.93	+8
5	Bulk Carrier	73000	0.63	0.64	-2
6	Container Carrier	120900	0.41	0.49	-17.0
7	Large Container Carrier	200000	0.38	0.45	-15
8	VLCC	363000	0.40	0.46	-12.8

Section 4, Table 1 gives an indication of the accuracy that can be expected from Kumai's formula. The table compares the prediction of the 2-noded vertical hull bending natural frequency by Kumai's formula with the predictions of detailed finite element calculations performed on different ships.

The 2-noded hull vertical bending natural frequencies actually lie well below the dangerous exciting frequencies of either typical diesel main engines or propellers, and are therefore of little consequence in these considerations. As will be demonstrated further on, it is hull girder modes with typically a minimum of 4 or 5 nodes that can be excited excessively by the diesel main engine. In the case of the propeller, the hull girder vertical bending modes that fall near full-power propeller blade-rate excitation are typically more than 7-noded. Full-power blade rate excitation of large ships is usually in the range of 8 to 12 Hz. As indicated in Section 4, Table 1, the 2-noded vertical hull bending mode, on the order of 1 to 2 Hz, is well below the blade-rate excitation frequency level during normal operation.

It is observed that hull girder natural frequencies increase more or less linearly with node number from the 2-noded value for the first few modes. The data shown on Section 4, Figure 1, from Johannessen and Skaar (1980), provide estimates of the natural frequencies of the first four vertical bending modes of general cargo ships and of the first five vertical bending modes of tankers. Note the good agreement for 2-noded cases. Also note that the 6 Hz maximums represented by Section 4, Figure 1 still lie well below typical full-power propeller excitation frequencies, and the accuracy of the data fits indicated on the figure is deteriorating rapidly as modal order increases. The primary reason for the increasing data scatter with node number is the increasing influence of local effects (i.e., approaching resonances of deckhouses, decks, etc.) on the basic beam modes still identifiable.

FIGURE 1
Natural Frequencies of Vertical Hull Vibration



The Kumai's formula, in conjunction with Section 4, Figure 1, is, however, useful in preliminary steps to avoid resonances with a main diesel engine. The following formula, from Johannessen and Skaar (1980), representing the Section 4, Figure 1 data, expresses the first few vertical bending natural frequencies in terms of the 2-noded value:

$$N_{nv} \approx N_{2v}(n-1)^\alpha$$

where

α	=	0.845	General Cargo Ships
		1.0	Bulk Carriers
		1.02	Tankers

Here N_{2v} is the 2-noded vertical natural frequency and n is the number of nodes; n is not to exceed 5 or 6 in order to remain within the range of reasonable validity. Note the approximate proportionality of N_{nv} to node number; this is also evident in Section 4, Figure 1. The use of this data is demonstrated by example:

- Assuming the “reefer,” ship number 1 of Section 4, Table 1, for example, $N_{2v} = 92.4$ cpm, and $\alpha = 0.845$. The first four vertical hull-girder modes of this vessel would then be predicted to have corresponding natural frequencies of:

n	N (cpm)
2	92.4
3	166
4	234
5	298

With the main engine RPM of 122 cpm, for example, the frequency of the 2nd order engine excitation is $2 \times \text{RPM} = 244$ cpm. It is relatively close to the predicted natural frequency of the 4-noded third hull girder mode. While the natural frequency estimate of 234 cpm is indeed rough, it provides at least useful guideline to dictate further analysis to refine the hull girder natural frequency estimates in this particular example.

In the case of projected high excitability in resonant vibration with the diesel engine moments, which does develop in the course of design on occasion, the excitation moment components can usually be reduced effectively by the incorporation of compensators or electric balancers. These devices consist of rotating counterweights usually geared directly to the engine, or electrically powered and installed at aft end of the ship. They are rotated at the proper rate and with the proper phase to produce cancellation with the undesirable 1st or 2nd order engine generated moment.

An alternative that has seen some popularity is the installation of main diesel engines on resilient mounts (Schlottmann *et al*, 1999). Isolating the main engine on resilient mounts can be a good approach to minimizing hull vibration and structure-borne noise. The following steps are therefore recommended in concept design:

- Assuming no moment compensation on the engine, compensators geared for $2 \times \text{Engine RPM}$, is to be installed on both ends of the crank if:
 - The full power second-order vertical moment amplitude exceeds the PRU (Power Related Unbalance) value of 220 N-m/kW, as discussed in Subsection 3/3.
 - Twice RPM of the engine at full power is within 20% of any of the vertical hull modes through at least 5-noded as predicted by the procedure of the immediately preceding example.
- Moment compensation is effective but should both a) and b) occur together, a more precise analysis of the hull girder natural frequencies is recommended in setting structure in preliminary design to more accurately assess the proximity of a resonance with the engine within a 20% band around twice full power engine RPM.

5 Main Machinery/Shafting System Longitudinal Vibration Excited by the Propeller

Shafting/machinery longitudinal vibration can also be serious in several respects:

- In a resonant or near resonant condition with the system mass and stiffness, thrust reversals at the main thrust bearing can result which, over a relatively short time period, are capable of destroying the thrust bearing;
- Engine room vibration, including vibration of the engine itself, can be excessive with regard to foundation and inner-bottom structural distress.
- The amplified thrust transmitted through the main thrust bearing and its moment arm relative the hull girder neutral axis can produce vertical response of the hull girder which excites resonant vibration of hull-mounted substructures.

Interest in longitudinal machinery vibration has a long history, starting seriously with the steam turbine-powered battle ships in WWII. It is considered necessary that longitudinal vibration be a subject of concept design. The main machinery items have long lead times and any problems are to be uncovered early.

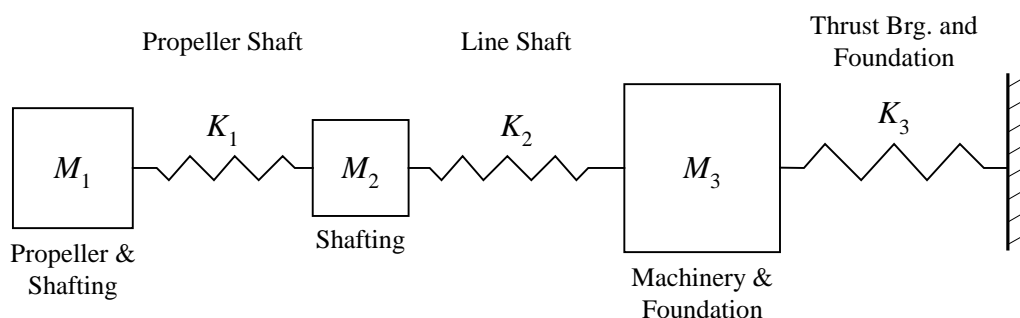
Main propulsion system fore-and-aft natural frequencies tend to fall in the range of propeller blade rate excitation frequency. For short shafting systems, the one-node (first) mode can be easily coincident with blade rate excitation, but with the second mode well above. For long shaft systems, the system just cannot be designed with the first mode above the blade rate excitation frequency, and must therefore be configured so that it lies far enough below. But then the second mode becomes of concern with long shaft systems.

The dominating uncertainty with regard to longitudinal vibration is the stiffness of the main thrust bearing and its “foundation.” The thrust bearing “foundation” is the serial ship structure that deflects, as a spring, in response to the thrust transmitted through the thrust bearing. The thrust bearing on a diesel is normally located in the engine casing aft. The long engine casing provides some extra stiffness over that with the steam plant. It is the serial stiffness in the engine room and ship bottom structure that can be the critically weak link; recall that in serial stiffness addition the overall stiffness is less than the stiffness of the most flexible element. This supporting structure must be carefully designed early to properly place the first two system natural frequencies relative to blade rate excitation in order to avoid serious problems. The control is through shipyard responsibility for the design of the engine room bottom structure and machinery foundations.

The three mass model of Section 4, Figure 2 can be used for first estimates of the first two shafting/ machinery system modes. Three masses are considered the minimum number needed for estimating the first two system modes with reasonable accuracy. Definition of the mass and stiffness data shown on the figure is as follows:

- M_1 = lumped mass at the propeller in kg, composed of propeller mass, increased 60% for hydrodynamic added mass, one half of the propeller shaft weight
- K_1 = stiffness of propeller shaft in N/m, from propeller to coupling with line-shaft
 $= AE/\ell_p$
- A = shaft cross-sectional area in m^2
- M_2 = lumped mass at propeller shaft/line shaft coupling in kg, composed of one-half of propeller shaft mass plus one-half of line-shaft mass. (For very short propeller shafts, M_2 could be located in the line-shaft with mass and stiffness contributions appropriately adjusted.)
- K_2 = stiffness of line-shaft in N/m, from coupling to thrust bearing (thrust bearing assumed to be at aft end of engine casing).
- M_3 = lumped mass at thrust bearing in kg, composed of one-half of the line-shaft mass, the engine, including the thrust bearing, plus a thrust bearing/engine foundation structural weight allowance of 25%.
- K_3 = stiffness of thrust bearing elements and engine foundation in N/m

FIGURE 2
3-mass Longitudinal Model of Main Propulsion System



It is convenient to view the foundation stiffness K_3 as an unknown, to be determined so that the two natural frequencies lie at appropriate levels with respect to the blade-rate excitation frequency. The coupled equations of motion lead to the eigenvalue problem:

$$\begin{bmatrix} -\omega_n^2 M_1 + K_1 & -K_1 & 0 \\ -K_1 & -\omega_n^2 M_2 + K_1 + K_2 & -K_2 \\ 0 & -K_2 & -\omega_n^2 M_3 + K_2 + K_3 \end{bmatrix} \begin{bmatrix} \psi_{n1} \\ \psi_{n2} \\ \psi_{n3} \end{bmatrix} = \begin{bmatrix} 0 \\ 0 \\ 0 \end{bmatrix},$$

where ψ denotes the mode shape vector. It is necessary to expand the determinant of the coefficient matrix to form the characteristic equation whose roots are the three natural frequencies. First define the following for convenience of notation:

$$\Omega_n \equiv \omega_n^2, \quad \Omega_{11} = \frac{K_1}{M_1}, \quad \Omega_{12} = \frac{K_1}{M_2}, \quad \Omega_{22} = \frac{K_2}{M_2}, \quad \Omega_{23} = \frac{K_2}{M_3}, \quad \Omega_{33} = \frac{K_3}{M_3}$$

Then the characteristic equation from the determinant expansion is the following cubic in Ω_n :

$$\Omega_n^3 + \Omega_n^2 (\Omega_{11} + \Omega_{12} + \Omega_{22} + \Omega_{23} + \Omega_{33}) - \Omega_n [\Omega_{11}(\Omega_{22} + \Omega_{23} + \Omega_{33}) + \Omega_{12}(\Omega_{23} + \Omega_{33}) + \Omega_{22}\Omega_{33}] + \Omega_{11}\Omega_{22}\Omega_{33} = 0$$

The unknown K_3 , in Ω_{33} , can be calculated for specified distributions of Ω_n in the ranges of interest.

$$\Omega_{33} = \frac{\Omega_n [\Omega_n^2 + \Omega_n (\Omega_{11} + \Omega_{12} + \Omega_{22} + \Omega_{23}) - (\Omega_{11}\Omega_{22} + \Omega_{11}\Omega_{23} + \Omega_{21}\Omega_{23})]}{-\Omega_n^2 + \Omega_n (\Omega_{11} + \Omega_{12} + \Omega_{22}) - \Omega_{11}\Omega_{22}}$$

The corresponding value to the required foundation spring constant is:

$$K_3 = M_3 \Omega_{33}$$

K_3 can then be plotted as a function of the arbitrary Ω_n to decide the stiffness of the structure that the shipyard is to design and build to provide the proper support stiffness for the system. It should be pointed out that on increasing the Ω_n from low values, K_3 will increase, and then will become negative as the second mode is reached. The stiffness subsequently turns back to positive again with further increasing frequency in the 2nd mode. The relevant ranges are the ranges of positive K_3 only.

Example:

Take the case used with the propeller example of the preceding sub-section, with the propeller RPM = 120 with 5-blades, implying a blade rate frequency of 10 Hz. The data used in this example are:

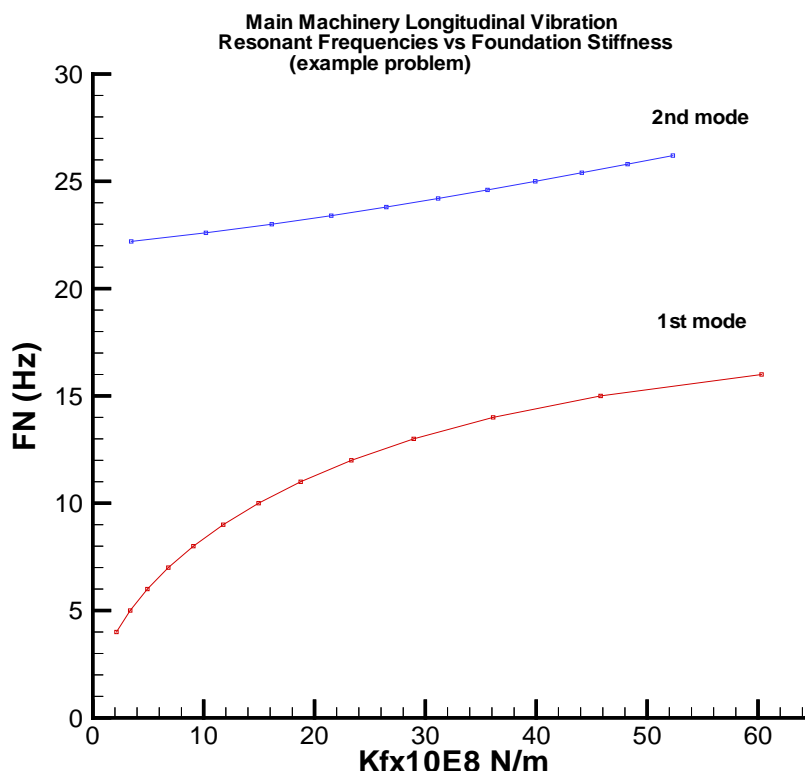
Propeller weight, $W_p = 24,098$ kg	Propeller shaft diameter, $d_{ps} = 9.45$ cm
Propeller shaft length, $L_{ps} = 15.24$ m	Line shaft diameter, $d_{ls} = 11.81$ cm
Line shaft length, $L_{ls} = 2134$ m	Engine weight, $W_e = 136,080$ kg

By the lumping scheme described above, the masses and springs are:

$M_1 = 65,770$ kg	$K_1 = 6,182 \times 10^6$ N/m
$M_2 = 62,050$ kg	$K_2 = 1,979 \times 10^6$ N/m
$M_3 = 204,940$ kg	$K_3 = K_f$ to be determined

Section 4, Figure 3 shows the plot of natural frequency versus thrust bearing and foundation stiffness for the first two modes.

FIGURE 3
Example of Natural Frequencies vs. Foundation Stiffness



The blade-rate exciting frequency on Section 4, Figure 3 is 10 Hz, so that the foundation stiffness is to be either sufficiently above or below approximately 15×10^8 N/m. The restricted frequency band is conventionally taken to be from 20% below the resonance to 20% above. Therefore, by this criterion, the stiffness is to be either below 9.5×10^8 N/m or above 24×10^8 N/m. Recall that K_f is the serial stiffness of the thrust bearing and the foundation; the thrust bearing stiffness is typically around 36×10^8 N/m. By the serial addition, this gives a higher required stiffness range for the foundation proper: below 12.9×10^8 or above 72×10^8 N/m. It is desirable to set the excitable natural frequencies above the excitation frequency range. Otherwise, a resonance falls within the operating range; in that case it must be assured that it is far enough below the full power blade-rate frequency.

In this particular example, which is not atypical, the 2nd mode is not of relevance as it lies well above the exciting frequency range for all foundation stiffnesses. As for the first mode, experience has shown that it would be impractical for the shipbuilder to build a foundation with a stiffness as high as 72×10^8 N/m. The available choice would be a foundation stiffness no higher than 12.9×10^8 N/m.

Designing a thrust bearing foundation for a specified stiffness is no simple matter, with shear deflection of the girders and bending deflection of the inner bottom out to some distance away typically involved. The best recourse is probably to design the double bottom to be as deep and stiff as possible within other constraints. This then helps to limit the deflecting structure to the foundation proper above the double bottom where it can be dealt with more reliably in detailed structural design.

The following steps are therefore recommended in concept design:

- i) Approximate the constants in the 3-mass model and perform the calculation of the combined thrust bearing and foundation stiffness.
- ii) Estimate the thrust bearing stiffness and perform the serial subtraction to establish a first estimate of the foundation stiffness. Graph the result in the form of Section 4, Figure 3.

- iii) If PRPM and blade number N have been tentatively set, select a foundation stiffness from the graph for which neither of the natural frequencies are within 20% of the full power blade-rate excitation frequency.
- iv) If PRPM and/or blade number have not been set, or *iii*) above cannot be achieved, select $\text{PRPM} \times N$ such that *iii*) is achieved. Preferably, select PRPM and N such that the first mode resonant frequency falls at least 20% above the full power blade-rate excitation to avoid a critical in the power range. ($N = 5$ blades is the best choice for minimum blade-rate alternating thrust for conventional stern ships with conventionally configured propellers, as discussed in Section 3).
- v) Provide the required foundation stiffness established to the hull structural designers for effecting in the preliminary/detailed structural design stages.

7 Superstructure Fore-and-Aft Vibration Excited

The movement of commercial ship engine rooms in the 1960's from amidship to the stern was a technological advancement in all respects except one: propeller-induced vibration. The movement was prompted by longitudinal strength as ships were becoming longer. But removing the structural discontinuity from the midship region and shortening the shafting system also reduced cost. However, wakes inherently became more irregular with the fuller sterns, and with the increasing ship power at that time, the role of propeller blade cavitation as a dominant vibration exciter quickly became apparent. In order to have unobstructed view over the ship bow from the aft-located bridge, elevation of the bridge atop a towering deckhouse was required. With this deckhouse necessarily mounted over the engine room cavity, adequate structural stiffness was difficult to incorporate. Then, with the house also located directly above the propeller, propeller-excited deckhouse vibration became the industries' troublesome problem.

As suggested in Subsection 4/3, a hull girder beam analysis which ignores the dynamics of superstructure produces useful estimates of the hull girder lower natural frequencies for purposes of resonance avoidance with a main diesel engine. It is indeed fortunate that the lower rocking/bending natural frequencies associated with stern superstructures, which usually fall in the range of propeller blade-rate exciting frequencies, can, conversely, be estimated with useful accuracy by ignoring the dynamics of the hull girder. This is the case when the mass of the superstructure is small, relative to the effective mass of the hull girder near the coupled natural frequencies of interest. Any consideration of vibratory response, versus natural frequencies alone, must, on the other hand, allow for the dynamic coupling. This is based on consideration of the fact that, in the preponderance of cases, superstructure vibration is excited by the hull girder vibration at its base. The superstructure vibration mode of primary concern is a fore-and-aft rocking/bending mode excited most often through vertical blade-rate vibration of the hull girder. This mode can also be excited indirectly at blade-rate frequency by longitudinal excitation from longitudinal resonance of the shafting/machinery system via the main thrust bearing (Subsection 4/5).

For obtaining preliminary estimates of superstructure fore-and-aft rocking/bending natural frequencies the semi-empirical method of Hirowatari and Matsumoto (1969) has proved to have great utility (Sandstrom and Smith, 1979). This method was developed from correlation of simple analysis and measured fore-and-aft superstructure natural frequencies on approximately thirty ships. In this method, the fore-and-aft "fixed base" natural frequency of the superstructure (i.e., superstructure cantilevered from the main deck) is determined according to deckhouse type and height. The fixed base natural frequency is then reduced by a correction factor to account for the rotational flexibility of the underdeck supporting structure. Specifically, the procedure of Hirowatari is as follows:

- i) Select superstructure type from Section 4, Figure 4.
- ii) Determine superstructure height, h .
- iii) Read f_{∞} (fixed-base natural frequency) as a function of h from Section 4, Figure 5.
- iv) Read f_c/f_{∞} (the correction factor) from Section 4, Table 2.

FIGURE 4
Deckhouse Types

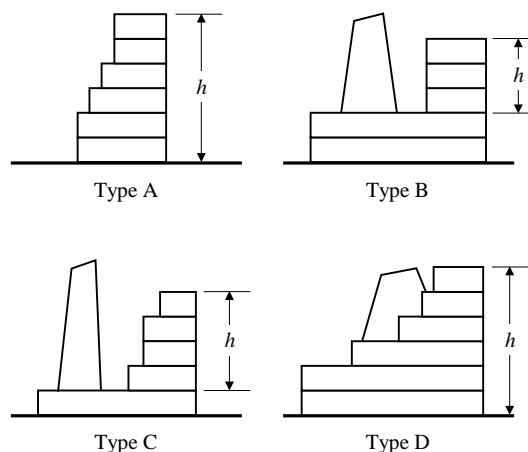


FIGURE 5
Fixed-base Superstructure Natural Frequencies

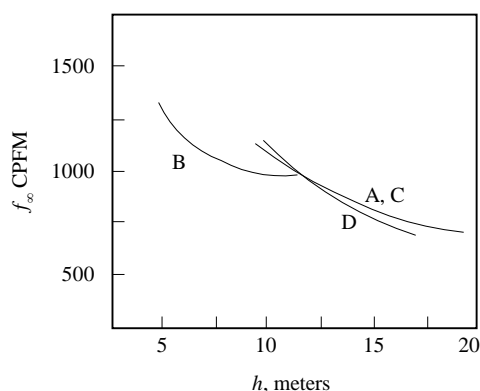


TABLE 2
Flexible Base Correction Factors

Type	f_e/f_∞
A, C	0.625
B	0.602
D	0.751

- v) Compute f_e (the expected deckhouse natural frequency in the first fore-and-aft mode) from the following formula:

$$f_e = f_\infty (f_e/f_\infty)$$

It is reported that this procedure generally produces results that are within 15 percent of measurements from shaker tests. However, the method becomes inapplicable when the superstructure type varies significantly from those given in Section 4, Figure 4. Furthermore, there is some uncertainty regarding the use of the correction factors for superstructure support flexibility given in Section 4, Table 2, since the supporting structure may vary from deep beams to column supports to structural bulkheads. Despite these difficulties, the method seems to work quite well in most cases, considering the limited input that is required. This feature makes the Hirowatari Method particularly attractive in the concept design stage when the design data are sparse or non-existent.

The two basic effects influencing the fundamental fore-and-aft superstructure natural frequency are exemplified in this approach:

- i) Cantilever (fixed base) bending and shear of the superstructure as a beam over its height h , Section 4, Figure 5.
- ii) Rocking of the superstructure as a rigid box on the effective torsional stiffness of its supporting structure.

Ordinarily, one of the superstructure main transverse bulkheads will be a continuation of one of the two engine room transverse bulkheads. The intersection of the continuous bulkhead and the deck identified with the superstructure base can usually be taken as the axis about which the rocking of the house occurs.

The fore-and-aft natural frequency of the superstructure due to the combined effects of rocking and bending/shear can be estimated using Dunkerley's equation (Thomson, 1973) as,

$$f_e = \sqrt{\frac{1}{1/f_\infty^2 + 1/f_R^2}}$$

Here, f_∞ has been identified as the fixed base cantilever natural frequency, from Section 4, Figure 5, or by detail analysis. f_R is the rocking natural frequency of the rigid superstructure, of height h , on its supporting stiffness,

$$f_R = 60 / 2\pi \sqrt{K_f / J} \text{ cpm}$$

J is the mass moment of inertia of the superstructure about the rocking axis and K_f is the effective torsional stiffness of the superstructure foundation, also about the axis of rotation. The Hirowatari procedure, in conjunction with the above formula, has utility in design or post design corrective studies where estimates must be made of the relative effects of structural changes. This is demonstrated by the following example:

Example:

Assume that a conventional Type A superstructure, Section 4, Figure 4, has been concept designed and that for the selected engine and propeller at full power, PRPM = 100 and $N = 5$, giving a blade-rate excitation frequency of 500 cpm. The house height, h , is 15 meters. Referring to Section 4, Figures 4 and 5 and Section 4, Table 2:

$$f_\infty \cong 800 \text{ cpm}$$

and

$$f_e/f_\infty = 0.625$$

This gives the estimated fore-and-aft house natural frequency, f_e , as:

$$f_e = 0.625(800) = 500 \text{ cpm}$$

which is precisely the full power blade rate excitation frequency. Proceed with the idea of stiffening the system in order to raise the natural frequency by the 20% minimum to 600 cpm. The rocking frequency is first estimated as,

$$f_R = \sqrt{\frac{1}{1/f_e^2 - 1/f_\infty^2}} = 640 \text{ cpm}$$

Then,

$$K_f/J = (2\pi/60)^2 f_R^2 = 4490 \text{ rad}^2/\text{sec}^2$$

Now assume that the mass of the house, m , has been estimated as 300 tonnes. Also assume that the house front is a continuation of the engine room forward transverse bulkhead, so that the house effectively rotates about its front lower edge, Section 4, Figure 6. Assume a radius of gyration, \bar{r} , of the house about this axis of 10 meters. The house mass moment of inertia, J , is then:

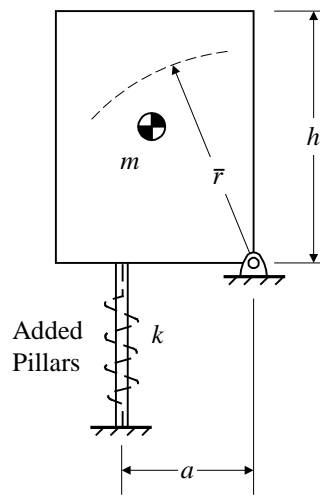
$$J = m \bar{r}^2 = 3 \times 10^7 \text{ kg-m}^2$$

The effective rotational stiffness of the foundation is then estimated as:

$$K_f = 1.35 \times 10^{11} \text{ N-m/rad}$$

Proceeding, assume that stiffening is proposed in the form of two parallel pillars made up of 20 cm extra-heavy steel pipe, each 6 meters long, and located under the house side bulkheads, as indicated on Section 4, Figure 6.

FIGURE 6
Deckhouse Stiffening



The effective axial stiffness of the parallel pillars is calculated to be $k = 5 \times 10^8 \text{ N/m}$. The pillars are located at a distance $a = 5 \text{ m}$ aft of the forward bulkhead, so that the incremental rotational stiffness added by the pillars is:

$$\delta K_f = ka^2 = 1.25 \times 10^{10} \text{ N-m/rad}$$

The stiffness of the stiffened foundation is

$$K'_f = K_f + \delta K_f = 1.475 \times 10^{11} \text{ N-m/rad}$$

which represents a 9.3 percent increase. The new rocking frequency becomes

$$f'_R = f_R \sqrt{1.093} = 669 \text{ cpm}$$

Then, the house fore-and-aft natural frequency is raised to:

$$f'_e = \sqrt{\frac{1}{1/f_\infty^2 + 1/f_R^2}} = 513 \text{ cpm}$$

This represents a 2.6 percent increase over the value of 500 cpm without the pillars, and far less than the 600 cpm judged to be needed. In order to achieve $f'_e = 600 \text{ cpm}$, reversing this last calculation gives $f_R = 907 \text{ cpm}$, and $K_f = 2.72 \times 10^{11} \text{ N-m/rad}$. This is about double the rotational stiffness of the original design. It would be essentially impossible to double the support structural stiffness if standard design features were employed.

In conclusion, the simple analysis of this example demonstrates the common misconception that vibration problems are always eliminated by stiffening the structure. This may be true for light structures such as mast, hand-rails, and the like, but with major substructures, such as a deckhouse, once the scantlings and principal dimensions are set incorrectly, the problem tends not to be correctable by simple stiffening, as the preceding example suggests. It may be possible to reduce stiffness to avoid a resonance, which was the spirit of the previous example on thrust bearing foundation stiffness in Subsection 4/5. But reductions in stiffness are generally undesirable. Stiffness reduction can result in excessive static deflection. As in the thrust bearing foundation stiffness example, the simplest recourse might be to change the engine RPM and/or the propeller blade number. In this current example, a switch from a 5 to a 6-bladed propeller with no structural changes would place the resonance in the operating range, but at the desired 20% below the new full power blade-rate exciting frequency of 600cpm.

The following specific steps are suggested for reducing the potential danger of excessive propeller induced deckhouse vibration at the concept design level.

- i)* Perform the preceding analysis on the candidate deckhouse and support structure design to predict the fore-and-aft rocking bending/shearing natural frequency.
- ii)* Compare the natural frequency with the blade-rate exciting frequency of any proposed engine and propeller characteristics. If the engine and/or propeller have not been proposed, note the blade rate frequency to be avoided in that ultimate selection.
- iii)* If the engine and propeller characteristics have been proposed and there is reluctance to change due to conflicts with other design considerations, establish the stiffness range of the deckhouse supporting structure calculated as necessary to avoid resonance within 20% of the full power blade rate frequency. This is just as recommended with the longitudinal vibration issue at the concept design stage. This defers the ultimate implementation to the preliminary/detailed designers who will at least have been made aware of the potential difficulty going in.



SECTION 5 Vibration Analysis

1 Introduction

1.1 Scope and Objective

The design and construction of a ship free of excessive vibration continues to be a major concern and, as such, it is prudent to investigate, through analysis, the likelihood of vibration problems early in the design stage. Vibration analysis is aimed at the confirmation of the many design considerations associated with:

- Stern configuration
- Main propulsion machinery
- Propeller and shafting system
- Location and configuration of major structural assemblies

The ship hull structure includes the outer shell plating and all internal members, which collectively provide the necessary strength to satisfactorily perform the design functions in the expected sea environment. The hull structure responds as a free-free beam (both ends free) when subjected to dynamic loads. The vibration induced by the propulsion system is a common source of ship vibration. The vibration from this source manifests itself in several ways. Dynamic forces from the shafting system are transmitted to the hull through shaft bearings. The propeller induces fluctuating pressures on the surface of the hull, which induces vibration in the hull structure. The main and auxiliary engines can directly cause vibrations through dynamic forces transmitted through their supports and foundations. The response to this forcing can cause the vibration of the hull girder, deckhouse, deck and other structures, local structures and equipment. When attempting to determine the source of vibration, it is necessary to establish the frequency of excitation and to relate the frequency of excitation to the shaft rotational frequency by determining the number of oscillations per shaft revolution. The main engine-induced unbalanced excitations encountered with slow-speed diesel-driven ships are the primary and secondary free engine forces and moments. The engine manufacturer is to provide the magnitude of these forces and moments.

The response of the hull structure may be resonant or non-resonant. The hull structure will normally vibrate in the following modes:

- Vertical bending
- Horizontal bending
- Torsional (twist)
- Longitudinal
- Coupling exists between horizontal and torsional modes, especially in containerships.

Typical major substructures include deckhouses, main deck structures and large propulsion machinery system, etc., which because of the direct coupling with hull structure vibration can significantly influence the total or global pattern of ship vibration. In analyzing vibration patterns of such large complex structures, it is necessary to identify the principal reason for observed excessive vibration. Excessive vibration of a major substructure may be the result of structural resonance in the substructure or in the attachment detail for the substructure and hull structure.

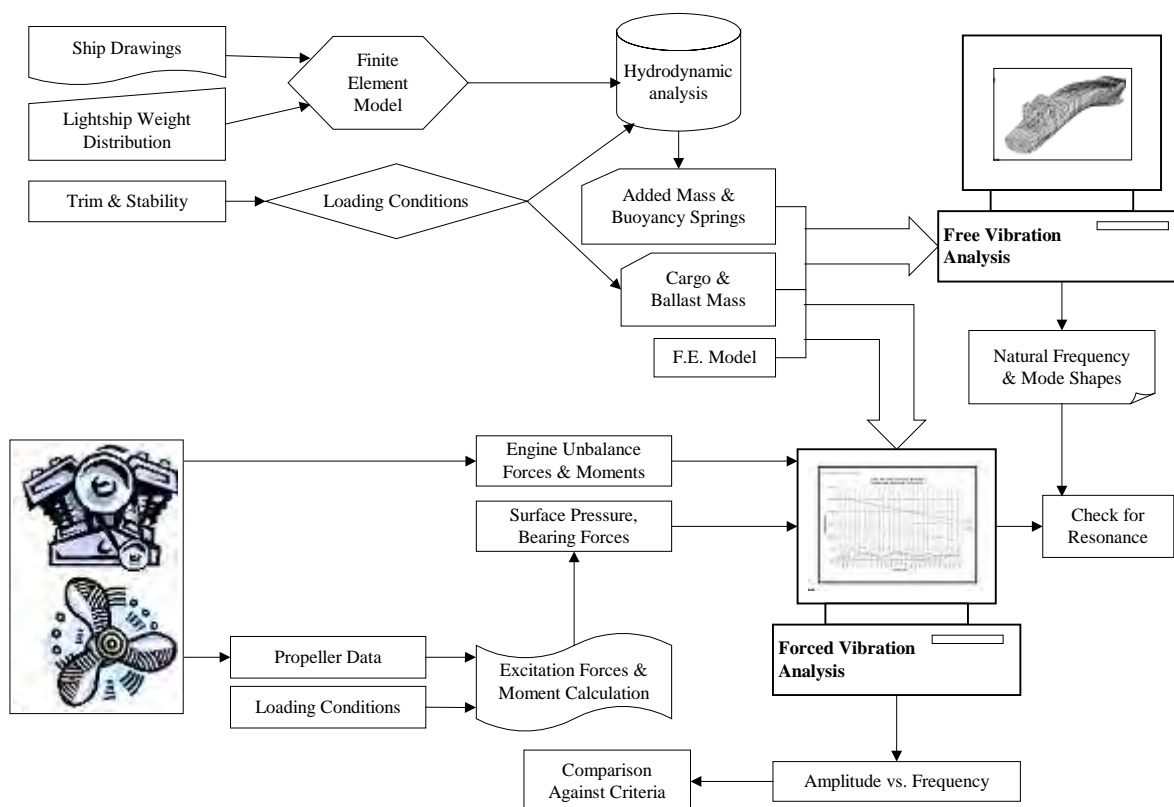
Local structural components are the minor structural assemblies, relative to major substructures previously referred to. Local structure may be identified as panels, plates, girders, bulkheads, platforms, handrails, minor equipment foundations, etc., and are components of larger structures (major substructures) or of the entire hull structure. Most ship vibration problems occur in local structural components and are the result of either strong inputs received from the parent structure amplified by resonance effects in the local structure or are the response to vibratory forces generated by mechanical equipment attached to the local structure.

This section describes the analysis procedure for propeller and main engine induced ship hull vibration using a three-dimensional finite element method. The objective of vibration analysis is to determine the overall vibration characteristics of the hull structure and major superstructures so that areas sensitive to vibratory forces may be identified and assessed relative to standard acceptance criteria on vibration level.

1.3 Procedure Outline of Ship Vibration Analysis

The flowchart of the procedure is shown in Section 5, Figure 1. The procedure recommended is to perform the vibration analysis using a three-dimensional finite element model representing the entire ship including the deckhouse and main propulsion machinery system. Both free and forced vibration analyses are included.

FIGURE 1
Procedure to Perform Ship Vibration Analysis



3 Finite Element Modeling

3.1 Global Model

3.1.1 General

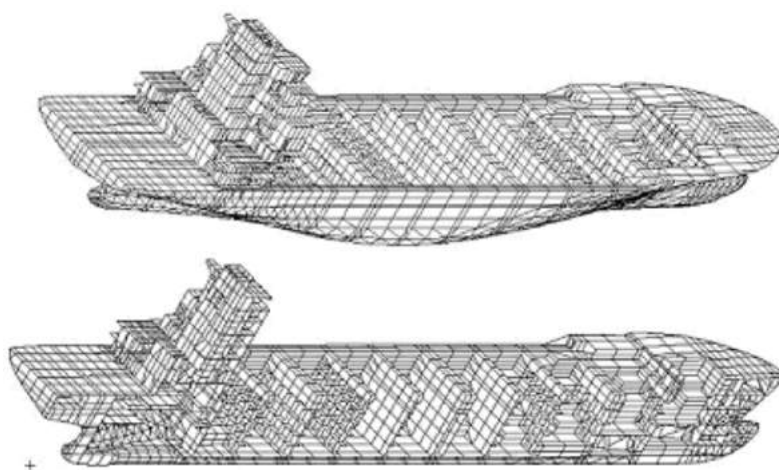
Ship structures are complex and may be analyzed after idealization of the structure. Several simplifying assumptions are made in the finite element idealization of the hull structure. The modeling requirements are that all significant structural sections are to be captured and deflection/velocity/acceleration are to be sufficiently predicted.

A three-dimensional finite element model representing the entire ship hull, including the deckhouse and machinery propulsion system, needs to be developed for vibration analysis. If a global model exists from any previous tasks such as stress analysis, it needs to be conditioned for vibration analysis.

3.1.2 Mesh Size

A judicious selection of grid points, elements and degrees of freedom may be used to fully represent the elastic and inertia properties of the structure while keeping the complexity of the data generation and the overall size of the model within manageable limits. Typically, a mesh size of three to four stiffener spacing for the overall ship structure is acceptable except for the stern and deckhouse structure. Bending plates and beam elements are to be used to achieve better structural stiffness representation. A finer mesh may be used in the areas of interest. Typical examples of such finite element models can be seen in Section 5, Figure 2.

FIGURE 2
Global FE Model Example



3.3 Engine, Propeller Shaft and Stern/Skeg

3.3.1 Main Engine

Care is to be taken when modeling the engine and surrounding structure. The engine foundation is to be modeled in detail. The engine can be modeled using solid or shell elements such that the mass, C.G and the engine stiffness matches the specifications of the engine. By assigning different densities of the material, mass and center of gravity of the engine can be controlled. In order to match the engine stiffness, different Young's moduli can be used for longitudinal and transverse structural members, respectively, based on the engine stiffness data provided by the engine manufacturer. An example of simplified diesel engine FE model is shown in Section 5, Figure 3. An example of a turbine engine FE model is shown in Section 5, Figure 4. Main engine top stays can be modeled as spring elements with spring coefficients obtained from manufacturer.

3.3.2 Propeller Shaft and Propeller

The propeller shaft is to be explicitly modeled such that it represents the proper stiffness of the shaft. It may be modeled with beam or bar elements. Care is to be taken when modeling the support bearings. The transverse supporting structure is to be modeled with the help of membrane shell elements. The tail shaft length is to be from the center of the propeller hub as shown in Section 5, Figure 5. The propeller may be modeled as a mass element.

3.3.3 Stern/Skeg Structure

Proper care is to be taken when modeling the skeg structure. Typically, the skeg structure is a thick casting. If it is modeled with shell elements, the thickness is to be increased appropriately to account for the stiffness of that structure.

FIGURE 3
Engine Model Example

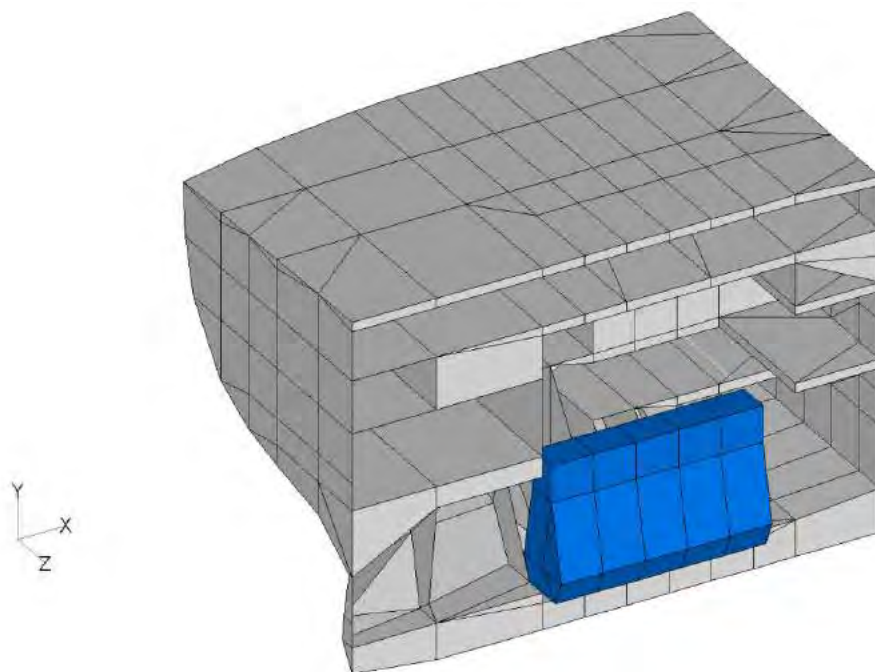
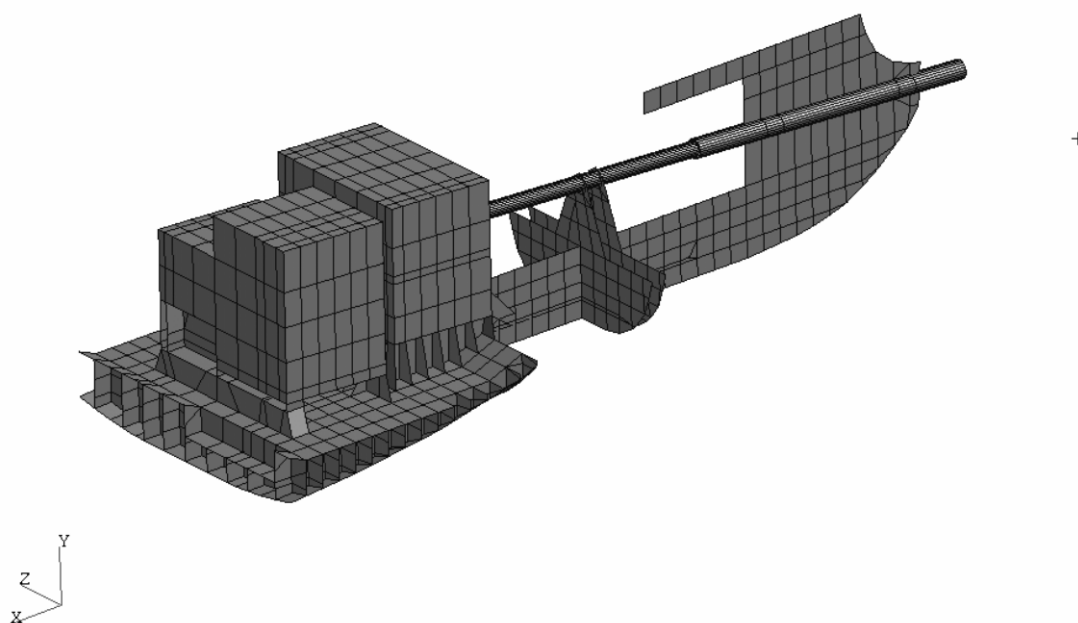
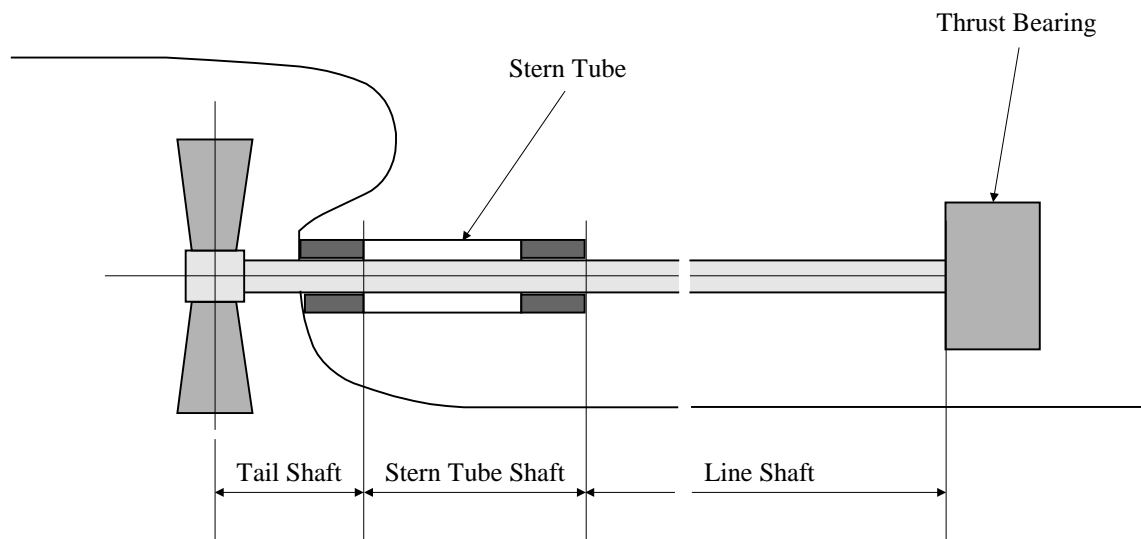


FIGURE 4
Turbine Engine and Propeller Shaft Modeling Example



**FIGURE 5
Propeller Shaft**



3.5 Lightship Weight Distribution

Lightship weight distribution is an important factor in any vibration analysis. Results can change dramatically if it is not properly represented. Typically, masses of all the heavy equipment are to be modeled as mass elements and are to be placed at well-supported nodes such that the total mass and center of gravity of that equipment are maintained. This distribution is to be as accurate as possible in the areas of interest. In general, the CG from the FE model and the CG from the T&S booklet is to be within 0.5% of the total ship length. The deckhouse superstructure weight and mass distribution, longitudinally and vertically, must also be accurately represented.

3.7 Cargo, Water Ballast in Tanks and Fuel Oil in Tanks

Mass elements can be applied to the tank boundaries to represent cargo, water ballast in tanks, and fuel oil in tanks.

3.9 Local Models

Typically local flexible plate panels are modeled in order to calculate the local natural frequencies. A number of plate panels are selected from the various decks, platforms, flats and bulkheads within the superstructure and regions of the hull for the natural frequency calculations. The panels selected are either typical locations or those locations expected to have the lowest natural frequencies in the areas of concern. In the calculations, the panel boundary support conditions are assessed from the local design arrangements. The mesh size can range from one or two elements between stiffeners to about six elements between stiffeners.

5 Loading Condition

5.1 Selection of Loading Conditions and Ship Speed

The objective of the vibration analysis is to investigate the ship vibration performance at intended service conditions. Therefore, the loading conditions, such as Full Load Condition and Ballast condition, in which the ship operates at ship design speed, will be the focus of the vibration analysis. In addition, it is often desirable to investigate the sea trial condition for the purpose of calibrating calculated numerical results with measurements. Typically, considering the analysis efforts to be taken, it is recommended that vibration analysis be performed for two selective conditions; either

- Full Load Condition and Sea Trial Condition, or,
- Full Load Condition and Ballast Load Condition

Depending on the loading condition, the mass of the cargo and ballast is then distributed in the structural model using mass elements. The corresponding added mass and the buoyancy springs are then calculated and added to the model.

5.3 Added Mass

The added mass can be considered through virtual mass method using boundary element method (BEM) such as 'MFLUID' card of MSC NASTRAN. Alternatively, a three-dimensional seakeeping analysis program may be used. The analysis includes three main tasks:

- *Development of a hydrodynamic panel model:* The hydrodynamic panel model is to represent the geometry of the ship's hull below the still-water line when using a linear seakeeping program. It is recommended that a total of about 2000 panels be used for the ship's hull surface, including port and starboard sides. A computer program may generate the panel model using the ship's offsets. The main particulars required for the hydrodynamic model includes: ship displacement, drafts, location of center of gravity and radii of gyrations.
- *Hydrodynamic analysis:* The purpose of the analysis is to obtain the distributed added mass. In general, the natural frequency of the ship is much higher than the wave frequencies considered in the seakeeping analysis. To obtain the added mass at such high frequencies, infinite frequency added mass option is to be used.
- *Mapping hydrodynamic results onto FE model:* The distributed added mass from the seakeeping analysis is represented as an added mass on each hydrodynamic panel model. An interface program can be used to map the heave added mass onto the FE model. The user needs to check that the total added mass on the FE model is equal to the total added mass on the hydrodynamic panel model.

5.5 Buoyancy Springs

The effect of buoyancy on hull vibration is generally regarded as small. Where it is necessary to consider the buoyancy effect, it may be modeled by adding rod elements to the wetted surface of the model. The rod elements work as springs and the total stiffness of the rod elements is to be equivalent to the ship's vertical buoyancy stiffness.

5.7 Special Conditions

Shipyards and/or ship owners may consider additional loading conditions to be investigated during the vibration analysis process.

7 Free Vibration

7.1 Analysis Procedure

Computation of the natural frequencies and mode shapes is to be performed by solving an eigenvalue problem. The natural frequencies (eigenvalues) and corresponding mode shapes (eigenvectors) of the three-dimensional finite element model can be obtained by solving the following equation of motion:

$$[M]\{\ddot{u}(t)\} + [C]\{\dot{u}(t)\} + [K]\{u(t)\} = \{F(t)\}$$

where

- $[C]$ = damping matrix
- $\{\ddot{u}\}$ = column matrix of accelerations
- $\{\dot{u}\}$ = column matrix of velocities
- $\{u\}$ = column matrix of displacements
- $\{F\}$ = column matrix of harmonic forces

For free vibration, damping $[C]$ and forces $\{F\}$ are zero. The solution would then be from:

$$[K]\{\Phi\} = \omega^2 [M]\{\Phi\}$$

where

$[K]$ = symmetrical stiffness matrix

$[M]$ = diagonal mass matrix

$\{\Phi\}$ = column mode shape matrix

ω = natural frequency

This problem can be solved by normal mode analysis. An important characteristic of normal modes is that the scaling or magnitude of the eigenvectors is arbitrary. Mode shapes are fundamental characteristic shapes of the structure, and are therefore relative quantities. Examples of mode shapes of a typical LNG carrier are shown in Section 5, Figure 6 and Section 5, Figure 7. The natural frequencies obtained from the analysis can then be compared to the excitation frequencies to check for resonance.

FIGURE 6
First Two Vertical Mode Shapes

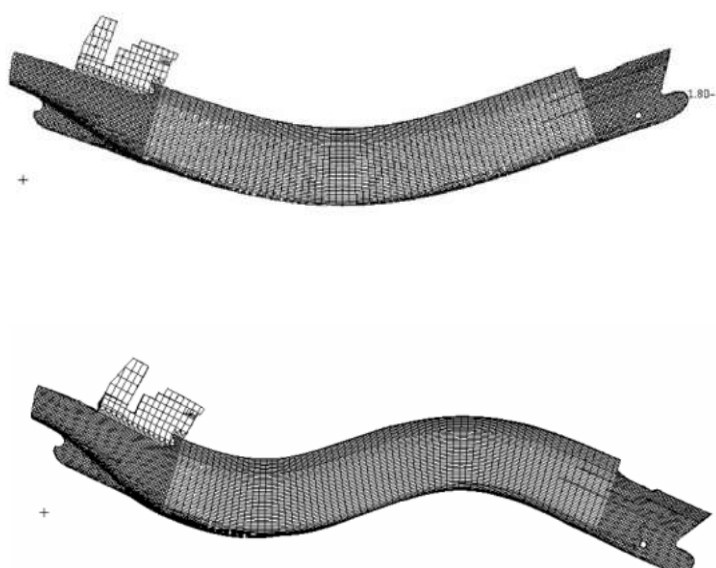
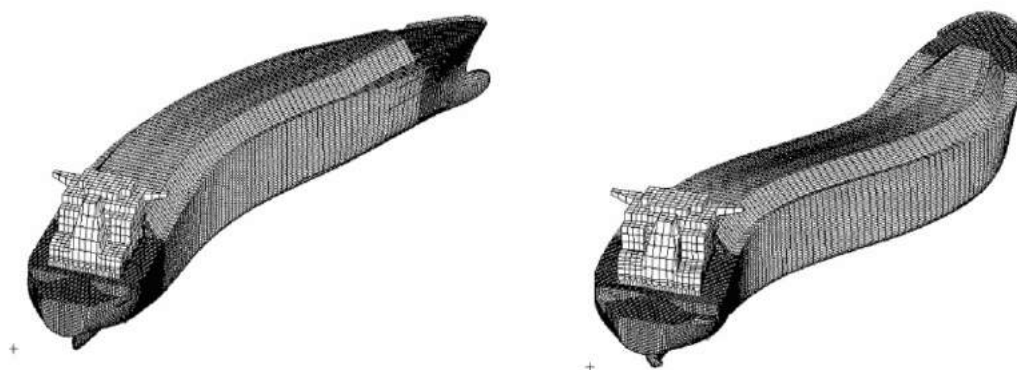


FIGURE 7
First Two Horizontal Mode Shapes



7.3 Checking Points

7.3.1 Mode Shapes

When performing free vibration analysis, it is important to validate the calculated results by investigating their mode shapes. There are several checking points:

- The first six mode shapes are to be rigid body modes and these six rigid body mode shapes, namely Pitch, Roll, Yaw, Surge, Heave and Sway, are not to display elastic distortion. Frequency is generally very low, well below the first elastic natural mode. Any mixing of rigid body modes and/or missing rigid body mode(s) would be a good indication of an erroneous FE modeling, especially when incorrect multi-point constraints are applied to the FE model.
- The first several elastic modes are to be for the hull structure. For typical commercial ships, there is usually no local modes below 4 Hz. Any “local modes” with low natural frequencies would be an indication of incorrect FE modeling. Too low frequencies are usually an indication of too high a mass or too low stiffness, or both.

It is a usual practice to investigate mode shapes up to at least twice the blade-rate frequency.

7.3.2 Natural Frequencies

Another checking point is to check the calculated natural frequencies from the free vibration analysis. Kumai’s formula in Subsection 4/3 for two-node vertical vibration may be used to preliminarily evaluate the calculated two-node natural frequency in order to verify that the FEM frequencies are in a proper range.

9 Propeller Excitation

9.1 Introduction

Excitation forces from the propeller are transmitted into the ship via the shaft line and also in the form of pressure pulses acting on the ship hull surface above the propeller. Whereas propeller shaft forces (bearing forces) are the most significant factor for vibrations of shaft lines, the predominant factor for vibrations of ship structures are the pressure fluctuations on the hull surface (hull surface forces).

9.3 Propeller Shaft Forces

9.3.1 General

Propeller shaft forces (bearing forces) are fluctuating load effects caused by the non-uniform wake inflow to the propeller. Usually, bearing force fluctuations transmitted from propeller to propulsion shafting are slightly affected by cavitation processes, if blade cavitation is not severe. In the absence of high shaft inclination, the magnitude of the bearing forces depends on the characteristics of the wake field, the geometric form of the propeller (in particular the skew and blade number), the ship speed and the rotational speed of the propeller. For a given application, the forces and moments generated by a fixed pitch propeller without severe cavitation are, in general, proportional to the square of the revolutions, since for a considerable part of the upper operational speed range the ship will work at a nominally constant advance coefficient.

Generally, the thrust fluctuation can be as high as 10% of the mean thrust, but it is usually between 2 to 8%. The force fluctuations in transverse and vertical directions are between about 1 to 2% of the mean thrust. In most cases, the moment fluctuation about the transverse axis is predominant (5 ~ 20% of the mean torque) compared to fluctuations of the moment about the vertical axis and of the torque (1~10%).

9.3.2 Previous Studies

In the 1980’s, an analytical investigation of 1st and 2nd blade rate bearing forces/moments was preformed for 20 ships (Veritec, 1985). The results of these calculations are useful for making preliminary estimates of the dynamic forces at the early stages of design. Section 5, Table 1 shows the results of these calculations in terms of the mean values and their ranges. In the Table, each of the six loading components is expressed in terms of the mean thrust T_o or the mean torque Q_o .

Propeller bearing forces and moments can excite various modes of vibration. For computations of axial and torsional vibrations of the shaft line, fluctuations in thrust and torque are to be taken into account. Bending vibrations of the shaft are influenced by transverse forces in horizontal and vertical directions as well as by bending moments about the corresponding axes.

TABLE 1
Propeller Bearing Forces and Moments for 20 Real Ship Case Study

				Blade Number		
				4	5	6
Blade rate frequency component	Thrust	$F_{x(1)}$	Mean	$0.084 T_0$	$0.020 T_0$	$0.036 T_0$
			Range	$\pm 0.031 T_0$	$\pm 0.006 T_0$	$\pm 0.0024 T_0$
	Vertical force	$F_{z(1)}$	Mean	$0.008 T_0$	$0.011 T_0$	$0.003 T_0$
			Range	$\pm 0.004 T_0$	$+ 0.009 T_0$	$\pm 0.002 T_0$
	Horizontal force	$F_{y(1)}$	Mean	$0.012 T_0$	$0.021 T_0$	$0.009 T_0$
			Range	$\pm 0.011 T_0$	$\pm 0.016 T_0$	$\pm 0.004 T_0$
	Torque	$M_{x(1)}$	Mean	$0.062 Q_0$	$0.0011 Q_0$	$0.030 Q_0$
			Range	$\pm 0.025 Q_0$	$\pm 0.0008 Q_0$	$\pm 0.020 Q_0$
	Vertical moment	$M_{z(1)}$	Mean	$0.075 Q_0$	$0.039 Q_0$	$0.040 Q_0$
			Range	$\pm 0.050 Q_0$	$\pm 0.026 Q_0$	$\pm 0.015 Q_0$
	Horizontal moment	$M_{y(1)}$	Mean	$0.138 Q_0$	$0.125 Q_0$	$0.073 Q_0$
			Range	$\pm 0.090 Q_0$	$\pm 0.085 Q_0$	$\pm 0.062 Q_0$
Twice blade rate frequency component	Thrust	$F_{x(2)}$	Mean	$0.022 T_0$	$0.017 T_0$	$0.015 T_0$
			Range	$\pm 0.004 T_0$	$\pm 0.003 T_0$	$\pm 0.002 T_0$
	Vertical force	$F_{z(2)}$	Mean	$0.008 T_0$	$0.002 T_0$	$0.001 T_0$
			Range	$\pm 0.004 T_0$	$+ 0.002 T_0$	$\pm 0.001 T_0$
	Horizontal force	$F_{y(2)}$	Mean	$0.001 T_0$	$0.006 T_0$	$0.003 T_0$
			Range	$\pm 0.001 T_0$	$\pm 0.003 T_0$	$\pm 0.001 T_0$
	Torque	$M_{x(2)}$	Mean	$0.016 Q_0$	$0.0014 Q_0$	$0.010 Q_0$
			Range	$\pm 0.010 Q_0$	$\pm 0.008 Q_0$	$\pm 0.002 Q_0$
	Vertical moment	$M_{z(2)}$	Mean	$0.019 Q_0$	$0.012 Q_0$	$0.007 Q_0$
			Range	$\pm 0.013 Q_0$	$\pm 0.011 Q_0$	$\pm 0.002 Q_0$
	Horizontal moment	$M_{y(2)}$	Mean	$0.040 Q_0$	$0.080 Q_0$	$0.015 Q_0$
			Range	$\pm 0.036 Q_0$	$\pm 0.040 Q_0$	$\pm 0.002 Q_0$

9.5 Hull Surface Forces Induced by Propeller Cavitation

9.5.1 General

Propeller-induced hull surface pressure fluctuations are more significant than shaft bearing forces. In merchant ships, for which a certain degree of propeller cavitation is generally tolerated for the sake of optimizing the propeller efficiency, about 10% of propeller-induced vibration velocities are caused by bearing forces, whereas approximately 90% are due to pressure fluctuations, or hull surface forces. In the design of ships having propellers with weak cavitation, the ratio may be reversed, while at the same time the absolute excitation level is much lower.

Pressure fluctuation is generally proportional to the acceleration of the propeller cavity volume. Calculation of the cavity volume may require knowledge of the pressure distribution on the propeller blade, both in the radial and circumferential direction. The flow condition in the tip region of the propeller blades has a particularly strong influence on cavitation processes. The formation and subsequent detaching of tip vortices additionally complicate the flow condition at the blade tips. Computer programs for the prediction of cavitation volumes are correspondingly complex.

To avoid strong cavitation-induced pressure amplitudes, the volume curve is to exhibit the smallest possible curvatures (note that pressure fluctuation is proportional to the acceleration of cavity volume). This can be achieved by influencing the wake (minimizing wake peaks) and by a suitable choice of propeller geometry. However, improved cavitation characteristics are usually offset for by reductions in efficiency. Selection of a larger area-ratio and reduction in propeller tip loading by selection of smaller pitch and camber at the outer radii are the most effective measures. In addition, by means of skew, a situation can be achieved where the individual profile sections of a propeller blade are not all subjected to their maximum loading at the same time, but instead the volume curve is rendered uniform by the offset in the circumferential direction. Some concepts tolerate comparatively severe cavitation and are aimed at making the growth and collapse of the cavitation layer as slow as possible.

From experience, the pressure amplitude above the propeller alone is not adequate to characterize the excitation behavior of a propeller. Therefore, no generally valid limits can be stated for pressure fluctuation amplitudes. These amplitudes depend not only on technical constraints such as achievable tip clearance of the propeller, power to be transmitted, etc., but also on the geometry-dependent compromise between efficiency and pressure fluctuation. Nevertheless, pressure amplitudes at blade frequency of 1 to 2, 2 to 8 and over 8 kPa at a point directly above the propeller can be categorized as low, medium, and high, respectively. Total vertical force fluctuations at blade frequency, integrated from pressure fluctuations, would range from 10 kN for a small ship to 1000 kN for a high performance container ship. Whether these considerable excitation forces result in high vibrations depends on the dynamic characteristics of the ship's structure and can only be judged on the basis of a forced vibration analysis.

9.5.2 Empirical Formulae

There are three methods for predicting hull surface pressure: by empirical methods, by calculations using advanced theoretical methods and by experimental measurements.

With regard to empirical methods, the most well-known and adaptable method is that of Holden, et al (1980). This method is based on the analysis of full-scale measurements for some 72 ships. The method is intended as a first estimate of the likely hull surface pressures using a conventional propeller form. Regression based formula for estimation of the non-cavitating and cavitating pressure are proposed as follows by Holden, et al.

$$p_o = \frac{(ND)^2}{70} \frac{1}{Z^{1.5}} \left(\frac{K_o}{d/R} \right) \quad \text{N/m}^2 \quad (\text{non-cavitating pressure})$$

and

$$p_c = \frac{(ND)^2}{160} \frac{V_s (w_{T \max} - w_e)}{\sqrt{(h_a + 10.4)}} \left(\frac{K_c}{d/R} \right) \quad \text{N/m}^2 \quad (\text{cavitating pressure})$$

where

N	=	propeller rpm
D	=	propeller diameter, in m
V_s	=	ship speed, in m/s
Z	=	blade number
R	=	propeller radius, in m

d	=	distance from $0.9R$ to a position on the submerged hull when the blade is at the T.D.C. (Top Dead Center) position (m)
w_{Tmax}	=	maximum value of Taylor wake fraction in the propeller disc
w_e	=	mean effective full scale Taylor wake fraction
h_a	=	depth of shaft centerline
K_o	=	$1.8 + 0.4(d/R)$ for $d/R \leq 2$
K_c	=	$1.7 + 0.7(d/R)$ for $d/R < 1$
K_c	=	1.0 for $d/R > 1$

The total pressure impulse, which combines both the cavitating ' p_c ' and non-cavitating ' p_o ' components, is then calculated from

$$p_z = \sqrt{(p_o^2 + p_c^2)}$$

Empirical methods of this type are particularly useful as a guide to the expected pressures. They should not, however, be regarded as a definitive solution, because differences, sometimes quite substantial, will occur when correlated with full-scale measurement. For example, p_c and p_o regression formulae give results having a standard deviation of the order of 30% compared to the base measurements from which it was derived.

9.5.3 Theoretical Method

In the case of a more rigorous calculation, more details can be taken into account, which results in a higher level of accuracy. Theoretical models, which would be used in association with this form of analysis, can be broadly grouped into the lifting surface or vortex lattice categories. In particular, unsteady lifting surface theory is a basis for many advanced theoretical approaches in this field. Notwithstanding the ability of analytical methods to provide a solution, care must be exercised in the interpretation of the results since these are particularly influenced by factors such as wake scaling procedures, the description of the propeller model and the hull surface, the distribution of solid boundary factors and the harmonic order of the pressure considered in the analysis. Furthermore, propeller calculation procedures assume a rigid body condition for the hull, and as a consequence do not account for the self-induced pressure resulting from hull vibration. These have to be taken into account by other means; typically, finite element models of the hull structure. As a consequence of all of these factors considerable care is to be exercised in interpreting the results. Analysis procedures for direct calculations of propeller-induced loads are briefly described in 5/9.7. For more details, refer to the ABS RPD2005-07 Technical Report 'An Integrated Computational Process for Cavitating Propeller Induced Loads'.

9.5.4 Model Tests

Model tests to predict hull surface pressures can be conducted in either cavitation tunnels or specialized facilities such as depressurized towing tanks. In the past, the arrangement in a cavitation tunnel comprised a simple modeling of the hull surface by a flat or angled plate above a scale model of the propeller. Although this technique is still used in some establishments, a more enlightened practice is to use a partial model with shortened body. Wake screens are typically used to fine-tune the wake field when a partial model is used for wake measurements. In some large facilities, however, a full-length ship model may be used. The advantage of using a model of the actual hull form is twofold: firstly, it assists in modeling the flow of water around the hull surface and does not require wake screens, and secondly it makes the interpretation of the measured hull surface pressure easier since the real hull form is simulated.

In order to interpret model test results, reference can be made to dimensional analysis, from which it can be shown that the pressure at a point on the hull surfaces above a propeller has a dependence on the following set of dimensional parameters:

$$p = \rho n^2 D^2 \Phi(J, K_T, \sigma, R_n, F_n, z/D)$$

where

ρ	=	water density in ton/m ³
n	=	propeller rps
D	=	propeller diameter in m
J	=	advance coefficient
K_T	=	propeller thrust coefficient
σ	=	cavitation number
R_n	=	Reynolds number
F_n	=	Froude number
z	=	distance from propeller to point on the hull surface in m

As a consequence of the above equation, a pressure coefficient K_p can be defined as follows:

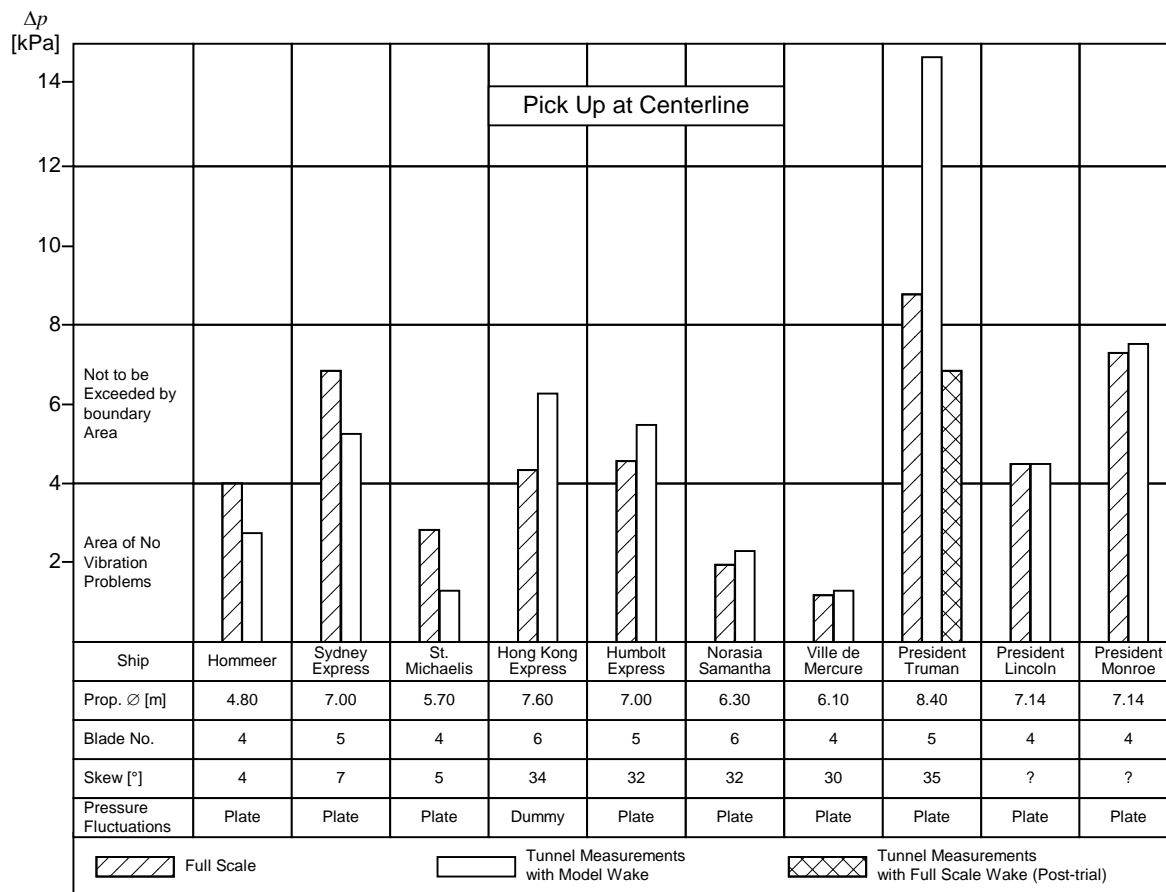
$$K_p = \frac{P}{\rho n^2 D^2}$$

As defined, dimensionless hull surface pressure is a function of propeller loading, cavitation number, geometric scaling, Froude number and Reynolds number.

In propeller cavitation tests, the test conditions are usually chosen such that the average propeller thrust loading (expressed by K_T and J -identity) is equal for model and full scale. In addition, the pressure is lowered to such a level that model and full size cavitation number are equal at corresponding points in the propeller disc. Furthermore, if the model test needs to fulfill Froude number identity, the test can only be realized in a depressurized towing tank or a tunnel with free surface. For a cavitation tunnel without a free surface, a rate of rotation for model scale is chosen within practical limits related to the tunnel capacity, the particular test set-up and the ranges of static pressure to be adjusted.

Although cavitation number and Froude number can be satisfied in most model tests, Reynolds number identity can seldom be fulfilled. This causes the well-known scale effect on the model test measurements. To take the scale effect into account in the model measurement, sometimes leading edge roughness for model propeller is used for tripping the flow over the propeller blades to turbulence. However, it also should be noted that scale effects exist not only on the flow around the propeller blade surface but also on the inflow toward propeller. Section 5, Figure 8 shows the comparisons of maximum propeller induced pressure between model scale and full-scale data. As seen, the discrepancies are notable. Usually, in order to obtain reliable model test results, model test measurement is to be appropriately calibrated based on full-scale data.

FIGURE 8
Scale Effect due to Propeller Inflow Condition



9.7 Direct Calculation of Bearing and Surface Forces

The overall calculation procedure for propeller loading calculation is as follows:

- Open water propeller flow analysis
- Nominal wake harmonic analysis
- Effective wake calculation – propeller/nominal wake interaction
- Propeller cavity pattern simulation
- Bearing forces/moments calculation
- Propeller induced hull pressure calculation

In order to perform the aforementioned analyses, the following information is to be required:

- Measured nominal wake
- Stern wave height
- Water temperature
- Ship speed
- Propeller rpm
- Draft
- Propeller blade number

- Propeller geometry (diameter, pitch, rake, skew angle, chord length, section profiles)
- Propeller location (related to ship hull)
- Ship stern geometry

11 Engine Excitation

The excitation forces and moments of low-speed diesel engine can be a significant source of hull vibration. Dominant forces acting on the engine structure originate from the combustion process (Guide Force Couples) and from the inertia of mass in motion (external forces). Guide force couples result from transverse reaction forces acting on the crosshead, causing rocking (H-couples), and twisting (X-couples) of the engine. These forces may cause resonance with the engine foundation structure. A possible solution for the eventual vibration problem may be installation of transverse stays (top bracings), connecting the engine's top structure to the ship hull.

Detailed consideration of the engine excitation forces and their effect on the ship hull structures is an important part in prevention of damaging structural vibrations. The magnitude of these forces and moments are to be obtained from the engine manufacturer.

13 Forced Vibration

13.1 General

Frequency response analysis is a method used to compute structural response to steady-state oscillatory excitation. The three-dimensional FE model is subject to systems of harmonic loads which represent the oscillatory excitation forces induced by propeller and main engine. Two different numerical methods can be used in frequency response analysis. A direct method solves the coupled equations of motion in terms of forcing frequency. A modal method utilizes the mode shapes of the structure to reduce and uncouple the equations of motion. The solution for a particular forcing frequency is obtained through the summation of the individual modal responses. The choice of the method depends on the model size, number of the excitation frequencies and the frequency of excitation. If the modal method is used, all modes up to at least two to three times the highest forcing frequency are to be retained.

A frequency response is obtained by applying the cyclic propeller and engine forces and moments with varying frequencies, related to the shaft rpm and the number of blades per propeller and the order of main engine, to the model and solving the resulting dynamic problem given by the following equation of motion.

$$[M]\{\ddot{u}(t)\} + [C]\{\dot{u}(t)\} + [K]\{u(t)\} = \{F(t)\}$$

where

$[C]$	=	damping matrix
$\{\ddot{u}\}$	=	column matrix of accelerations
$\{\dot{u}\}$	=	column matrix of velocities
$\{u\}$	=	column matrix of displacements
$\{F\}$	=	column matrix of harmonic forces

The structural response to this harmonic load is a steady state response at the frequency of the load. (It is assumed that the harmonic load continues long enough so that the transient response damps out). Therefore:

$$F(t) = F e^{i\omega t}$$

$$u(t) = u e^{i\omega t}$$

Upon substitution, the equations of motion reduce to:

$$[K + i\omega C - \omega^2 M] \{u\} = \{F\}$$

It is noted that both $\{F\}$ and $\{u\}$ are complex quantities due to damping C and to the fact that the various components of propeller and engine induced vibratory forces are not in phase with one another.

13.3 Critical Areas

In order to demonstrate the frequency response in terms of peak velocities within a certain structure without losing generality, a fairly large quantity of grid points within the structural model may be selected and their responses may be obtained in the form consisting of magnitudes and phase angles rather than complex components. Here is a list of the typical critical areas that are to be taken into consideration in any vibration analysis.

- Transom at Centerline
- Transom at Port and Starboard Side
- Point right above the propeller
- Deck house:
 - Port and Starboard side at Bridge
 - Centerline at Bridge
 - Port and Starboard side at top of deck house (Wheel House)
 - Centerline at top of deck house (Wheel House)
 - Centerline at upper deck (Forward and Aft)
- Centerline at stern
- One point on each cargo Hold on the transverse Bulkhead.
- Engine room areas
- Machinery areas.
- Skeg area.

Depending on the ship type, there may be additional areas of investigation. Care is to be taken to model the masses of the equipment. They are to be located on well-supported nodes as much as possible. A computer program may be used to post process the results obtained from the forced vibration analysis.

13.5 Damping

The total damping associated with overall ship hull structure vibration is generally considered as a combination of the following components:

- Structural damping;
- Cargo damping;
- Water friction;
- Pressure wave generation;
- Surface wave generation.

For the forced vibration analysis, it is assumed that the effects due to structural damping, cargo damping, water friction and pressure wave generation can be lumped together. The effect of surface wave generation needs only to be considered for very low frequencies of vibration. This effect is generally neglected. For simplification, a constant damping coefficient of 1.5 percent of the critical damping may be used for the entire range of propeller rpm and main engine orders. Otherwise, more detail frequency-dependent damping coefficients may be used, if applicable.

SECTION 6 Measurements

1 General

1.1 Scope

These Guidance Notes provide general guidelines on the measurement and evaluation procedures for the vibration of hull girder and superstructure, local structures, main propulsion machinery and shafting, other machinery and equipment. This section covers overall procedures for acquiring, processing, and presenting data collected during sea trials based on ISO 4867 and SNAME T&R No. 2-29.

1.3 Application

The procedures provided are applicable to both turbine and diesel-driven vessels of all lengths. Actual items for measurements are to be determined as appropriate based on ship specifications or specific needs requiring the measurements.

1.5 Terminology

- *Average Amplitude Value*: The value obtained from an Fast Fourier Transform (FFT) signal analyzer, set in the averaging mode, equal to $\sqrt{2}$ times the value read from the amplitude spectrum, which is an rms level. This is equivalent to the average sinusoidal value obtained during steady speed trial conditions, and for design purposes, it is comparable to predicted response.
- *Free Route*: That condition achieved when the ship is proceeding at a constant speed and course with minimum throttle or helm adjustment.
- *Hull Girder*: The primary hull structure such as the shell plating and continuous strength decks contributing to flexural rigidity of the hull and the static and dynamic behavior of which can be described by a free-free non-uniform beam approximation.
- *Hull Girder Vibration*: That component of vibration which exists at any particular transverse plane of the hull so that there is little or no relative motion between elements intersected by the plane.
- *Local Vibration*: The dynamic response of a structural element, deck, bulkhead or piece of equipment which is significantly greater than that of the hull girder at that location.
- *Maximum Repetitive Amplitude (MRA)*: This is the largest repeating value of the modulated signal obtained on sea trial. It can be observed in the envelope of peak values on a time compressed strip chart of the modulated signal. This is the acceptance value specified in the codes.
- *Conversion Factor (C_F)*: The ratio of the MRA to the average amplitude obtained during steady speed trial condition.
- *“Peak Hold”*: Most FFT analyzers include a feature called “Peak Hold” which generates a spectrum of values which are the maximum spectral values in each frequency component for the set of all individual spectra comprising the “Peak Hold” spectrum. This is not the same as the MRA. In operation it represents an average value of a number of cycles of the signal evaluated rather than the maximum value of the single largest amplitude observed. The number of cycles averaged is based on the “window” or viewing time in seconds and, of course, increases with frequency.
- *RMS Value*: The root mean square value is the square root of the sum of the squares of all points of a signal. For a sinusoid, it is .707 times the single amplitude.
- *Severity of Vibration*: The peak value of vibration (velocity, acceleration or displacement) during periods of steady-state vibration, representative behavior.

3 Instrumentation

3.1 General Requirements

Measurements are preferably to be made with an electronic system which produces a permanent record. The transducers may generate signals proportional to acceleration, velocity or displacement. Recording can be made either on magnetic tape, paper oscillographs, or in digital format. Use of paper oscillographs during the tests means that the vibration traces can be inspected directly and is very helpful in evaluating existing vibration problems. When displacement rather than either velocity or acceleration is recorded, the desired low-frequency signals associated with significant vibratory motion are the major components of a recorded trace. Thus, they are readily evaluated since they overshadow possible higher frequency signals with low displacement amplitudes. Provisions are to be made for suitable attenuation control to enable the system to accommodate a wide range of amplitudes.

An event marker is to be provided on the propeller shaft. Its position with respect to top dead center of cylinder number 1 and a propeller blade is to be noted.

3.3 Calibration

Calibration procedures are categorized as system calibration or electrical calibration. In general, system calibration refers to a procedure that is done before installing instrumentation on board of the ship or as the transducers are installed. It is to be a complete reckoning of the sensitivity of the transducers, signal conditioning and recording equipment.

Electrical calibration refers to a procedure that can be accomplished usually at the recording center, is considered a “spot check,” takes only a few minutes, and can be done periodically during the vibration trials. Calibration procedures are different for different types of gauges and are discussed in this section.

3.3.1 Accelerometers

All accelerometers can be calibrated over the frequency range of interest by mounting on a shaker table or calibration device that is oscillating at known amplitudes. Normally, this is the type of system calibration that is used. Strain gauge and piezoresistive accelerometers can be calibrated for zero, ± 1 g by laying them on their sides, their bases and upside down, respectively. This provides a D.C. calibration only and is useful only if the conditioning and recording equipment operates at a frequency of zero Hz.

Once the transducers are installed, the “electrical calibration” is usually accomplished by an internal (to the amplifier) signal of known value being applied to the conditioning and recording equipment. In the case of strain gauge and piezoresistive accelerometers, a shunt resistor can be applied across one arm of the bridge and the value of the resistor can be equated to a certain acceleration. The latter results in a D.C. step being recorded.

3.3.2 Velocity Gauges

System calibration for velocity gauges is to be done on a shaker table that oscillates at known amplitudes and frequencies. There are no D.C. types of calibration suitable for these gauges. Electrical calibration is done by means of an internal signal of known value being fed into the conditioning and recording equipment. Since the conditioning equipment usually does not operate for D.C. signals, the known signal is usually a sinusoid.

3.3.3 Proximity Probes

Proximity probes should not be sensitive to changes in frequency and therefore can be calibrated for D.C. steps only. They are to be calibrated at several distances from the target by means of “feeler” gauges. Plastic feeler gauges are available that do not affect the signal and can be left in place while recording. Preliminary calibration can be done before installing the probes on board ship, but the final calibration is to be done with the probes in place because each target has a slightly different effect on the gauge. The only practical type of “electrical” calibration would be the substitution of a signal of known value.

3.3.4 Strain Gauges

The type of calibration used with strain gauges will depend on how they are used. Again the signal output should not be sensitive to frequency and D.C. calibrations are adequate. If possible, the strain-gauged object is to be subjected to known loads and the resulting strains calculated and related to the signal output. If the object has a complex shape or if known loads are difficult to apply, the only choice is to accept the manufacturers' listed Gauge Factors and use a shunt resistor for calibration.

In most applications on board ship, the signal leads from the strain gauges are fairly long. This reduces the sensitivity of the gauges, requiring the shunt to be applied at the gauge rather than at the amplifier in order to obtain accurate results.

5 Measurement Conditions

Vibration tests are to be conducted under the conditions that are agreed by the shipyard and owner. The following measurement conditions are provided as a reference.

5.1 Environment Condition

5.1.1 Sea State

The test is to be conducted in a sea state no greater than the following as far as practicable:

- Sea state 1 for small craft
- Sea state 2 for small ships (<10,000 tonnes)
- Sea state 3 for large ships (>10,000 tonnes)

The actual sea state during the vibration measurement is to be clearly stated in the report.

5.1.2 Water Depth

The test is to be conducted in a water depth of not less than five times the draft of the ship, with machinery running under normal conditions. If a vessel normally operates in shallow water, the depth during the time of the test is to be representative of normal operating depths.

5.3 Loading Condition

The ship is to be ballasted to a displacement and trim as close as possible to the normal operating conditions within the ordinary ballasting capacity of the vessel. The draft aft is to ensure that the propeller is fully immersed.

5.5 Course

Tests are to be conducted for the following courses:

5.5.1 Free-route Runs

During the free-route runs, the rudder angle is to be restricted to two degrees port or starboard. Rudder action is to be kept to a minimum.

5.5.2 Maneuvers

Tests may also be conducted while completing the following maneuvers:

- Hard turn port
- Hard turn starboard
- Crashback

In general, these tests are normally required for naval combatants or small craft.

5.7 Speed and Engine Power

Free-route runs are to be conducted at constant speeds from half shaft rotational speed or less (generally idle speed for diesels) to the maximum speed, using at least 10 equally spaced increments. Additional runs are to be made at smaller increments near each critical speed (the calculations will assist in locating criticals) and each service speed. If there are multiple shafts or propellers, all are to be run as close as possible to the same speeds (generally within two percent). In certain instances, it may also be appropriate to run with a single shaft or propeller.

Tests for hard turns to port and starboard are to be conducted at maximum speed. The crashback test is to be performed starting from the maximum speed and decreasing the propeller rpm at 10% of the maximum rpm per minute or less.

7 Measurement Locations

7.1 Stern

Vertical, transverse, and longitudinal measurements of the hull girder are to be taken at the centerline and as close as possible to the stern by means of a transducer. These measurements are to be for reference purposes. A pair of transducers for vertical vibration are also to be placed at the deck edge (one port, one starboard). They are to be located on the same deck and longitudinal location as the aforementioned transducer. It is to be ensured that the vibration of the hull girder is measured, excluding local effects.

7.3 Superstructure

Vertical, transverse, and longitudinal vibrations are to be measured at the following locations:

- Wheel house (navigation bridge), centerline at front of bridge
- Bridge wing aft end
- Main deck, centerline at front of deck house
- A pair of transducers to measure torsional motions of an aft deck house, when torsional vibration is to be determined

Measurements are to be made in the range of 90 to 100 % normal shaft rotational frequency.

7.5 Main Engine and Thrust Bearing

7.5.1 Geared Drive Turbines

Vertical, transverse and longitudinal measurements are to be taken on top of the thrust bearing housing. Recordings are also to be taken on one additional point on the thrust block foundation in the longitudinal direction. Measurements at other locations may be executed as optional. Other measurements to achieve the same results are permissible.

7.5.2 Direct Drive Diesels

Recordings are to be taken at the following locations:

- Top and foundation of the thrust bearing; if applicable;
- Top forward end of the main engine, in the longitudinal direction;
- Top forward and aft ends of the main engine, in the vertical and transverse directions;
- Forward end of the crankshaft, in the longitudinal direction;
- Forward and aft ends of the engine foundations, in the vertical and transverse directions.

For the other measuring points, optional recordings may be taken at constant shaft rotational frequency. Measurements are to be made throughout the normal operational range of the ship.

7.7 Lateral Shaft Vibration

If measurement is conducted, vertical and transverse vibration measurements are to be made on the shaft relative to the stern tube. Additional measurement points are optional and may be taken. These measurements are to be made throughout the normal operational range of the ship.

In order to eliminate possible error, shaft run-out is to be checked by rotating the shaft by the turning gear and recording the first-order signal. This signal is to be phased and the shaft vibration measurement corrected accordingly.

7.9 Torsional Shaft Vibration

If measurement is conducted as per 4-3-2/7.5.8 of the ABS *Steel Vessel Rules*, torsional vibration measurements are to be taken either at the free end of the propulsion machinery, using a suitable torsional vibration transducer, and/or on the main shafting, using strain gauges. Alternatively, depending on the system characteristics, a mechanical torsigraph, driven from a suitable position along the shafting or free end, may be used for this purpose.

7.11 Local Structures

If severe local vibration exists during sea trials, vertical, transverse, and longitudinal measurements are to be taken at the suspect location. This is necessary in order to determine the need for corrective measures.

7.13 Local Deck Transverse

Vertical and transverse bending vibration measurements are to be taken at the deck edge using a significant number of points necessary to determine the mode shapes at low frequencies while avoiding local resonances. These types of measurements are to be made by use of a reference transducer at the stern along with a portable transducer. Torsional modes may require phased deck-edge measurements.

7.15 Local Machinery and Equipment

Vertical, transverse and longitudinal measurements are to be taken at the outside of machinery where there is evidence of large vibration amplitudes. Types of machinery and equipment include diesel generator, electric motors, air compressors, ballast pumps, etc. Vibration measurement is to be taken at the bearing position.

7.17 Shell Near Propeller

If necessary, the measurements of hull surface pressure are to be taken in order to confirm design estimates, to obtain design data or to investigate potential cavitation problems. The pressure transducers are to be located as follows:

- Two transducers in the propeller plane;
- One transducer at 0.1 D forward of the propeller plane

To minimize the effect of plate vibration, all transducers in the hull plating are to be located as close as possible to adjacent frames or partial bulkheads.

9 Data Processing Analysis

9.1 Measured Data

9.1.1 Displacement, Velocity, Acceleration

The type of data that is to be recorded (displacement, velocity or acceleration) may depend on the appropriate frequency range. For example:

<i>For Frequencies</i>	<i>Measure</i>
Below 300 rpm	displacement
Between 300 rpm and 6,000 rpm	velocity
Above 6,000 rpm	acceleration

If a particular data type is critical in determining damage to machinery or structure or for human response, the appropriate data type may be used in-lieu of that above. For example:

<i>For</i>	<i>Measure</i>
Mechanical or structural fatigue	displacement
Human response	velocity
High frequency machinery components	acceleration

9.1.2 Frequency Range

The frequency ranges of transducers, signal conditioners and recording equipment are to be chosen to match the frequency components of interest in the data being recorded. Frequencies that are known to be present but not of interest are to be excluded.

Do not record unwanted frequencies. This will make it difficult to separate the level of the frequency components of interest from the “noise.” Also, do not choose a frequency analyzer with a broader range than necessary. This will decrease the resolution and accuracy of the results.

TABLE 1
Typical Frequencies Ranges

<i>Item</i>	<i>Frequency Range</i>
Ship motion	Below 1 Hz
Major structure (deckhouses, masts, etc.)	Between 1 Hz to 10 Hz for the lower modes
Propeller shaft rotation, gear frequencies, and blade rate	To be determined from the machinery characteristics

9.1.3 Time History or Frequency Spectra

In case where the vibration is self-excited, such as rotating machinery, obtaining the frequency spectra directly is appropriate. In this case, amplitudes are fairly constant and a large sample is not required. However, most vibration data gathered from ships are excited by the sea, propeller or some combination (e.g., hull girder vibration). For this type of data, the amplitudes are modulated and have a randomness associated with them and may require a sample large enough to account for the randomness, which for blade frequencies and its harmonics are to be three minutes.

9.3 Performance of Measurements

- For the free-route run, data are to be recorded for at least three minutes after steadying at each ship speed, or for at steadily increasing shaft speed less than 1rpm per 5minutes.
- For the hard turns to port and starboard, recording is to commence before the turn and continue until maximum vibration has passed (when settled into the turn).
- For the crashback test, data are to be recorded before the propeller rpm is reduced and continue until the ship comes to rest.

9.5 Analysis Methods

The methods of analyzing shipboard vibration data are presented in SNAME T&R No. 2-29. The manual method is to be used by an engineer during sea trial in order to complete a quick assessment of test results and to identify potential problems. For the final test report, the use of the fast digital electronic (FFT) analyzers is to be employed. For more details, refer to SNAME T&R No. 2-29.

9.5.1 Manual

The manual method of analysis involves measuring frequencies and amplitudes of vibration components from an oscillograph record. The analysis of periodic waveforms is based on the principle that any periodic record is a superposition of sinusoids having frequencies that are integral multiples of the lowest frequency present. The lowest frequency is determined by the smallest portion of the record that repeats itself, or one cycle.

Ship vibration often involves more than one component, so that decomposing the signal into its separate components would mean discerning beating and modulating and applying the appropriate analysis techniques. Thus, having magnetic tape of the actual recorded signal available for detailed analysis, as applicable, is highly recommended.

9.5.2 Envelope

This method of analysis consists of filtering the signals to obtain the MRA of a narrow frequency band of interest and recording the result on a chart recorder at slow play out speed. This condenses a several minute record into an envelope just several inches long, from which the MRA can be visually noted. Care must be taken that the filter used does not pass a significant amount of any component other than that of the component of interest. For this reason it is important to use precision filters.

This method is the most direct approach to the determination of the MRA of individual components. If the MRA of the multi-frequency amplitude is required, the desired response would be obtainable by simply recording the real-time record at a slow speed and measuring the overall amplitude and multiplying by the sensitivity of the measuring/recording system. However, for obtaining the amplitudes of individual components for use in evaluating design analyses and/or developing improved crest values to be used in conjunction with spectral analyses, it will be necessary to include filtering systems.

9.5.3 Spectral

Two common types of spectra that can be found with most analyzers are the “average” and the “peak” amplitude. For both types, the record is broken down into segments for frequency analysis. The segments vary in length with the frequency range of the analysis, but for ship vibration studies they would be several seconds long. For each segment, the analyzer finds the rms level of each frequency component (i.e., in each frequency interval, or for each “line”). The number of lines (resolution) varies with the analyzer, but most often falls between 100 and 1000. Ship vibration records will normally be one or several minutes long and will contain many segments. If the “average” spectrum is chosen, the analyzer will average all the rms levels found in like frequency intervals and produce the “average” spectra as “average rms” values. This value will correspond to the rms value shown in the ISO-6954 formula:

$$(MRA) = (C_F \sqrt{2}) \times \text{rms value}$$

where C_F denotes “conversion factor” and $C_F \sqrt{2}$ denotes “crest factor”. The average value, or average amplitude is equal to $\sqrt{2}$ times the “average rms” value read from the “average” spectrum. This is equal to the average sinusoidal value obtained during steady speed trial conditions and, for design purposes, is comparable to predicted response.

The term “peak” is frequently misinterpreted when used in conjunction with the application of the spectral analyzer in the evaluation of shipboard hull vibration. To clarify the use of the term, note that the peak value of any vibration cycle is the difference between the mean and maximum values of that cycle. However, in the case of a modulating signal we note that the “peak” value increases to a “maximum” value, every few cycles. Thus, the “peak” of the modulating signal represents the maximum repetitive value or MRA and is actually equivalent to the peak value of each segment and corresponds to “peak hold” for that segment.

When choosing the “peak” spectrum, the largest rms values are obtained in each frequency interval found among several segments. These values are called “peak rms” values with some variation in results, depending on the frequency range used. A higher frequency range will involve broader frequency intervals and yield higher results. The average spectral value will always be less than the MRA. The relationship between the latter two will depend on the rate of modulation compared to the length of the segment. If the modulation is very slow, the amplitude will be near its maximum for the entire length of some segments and the two will be close. If the modulation is fast, the peak will be closer to the average amplitude.

The amplitude variation at blade-frequency between “average spectral”, “peak spectral” and *MRA* (derived by the envelope method) is shown in Section 6, Table 2 for example. The data represents the average of three full-power runs measured at 114 rpm, and shows alternating pressure measured over the propeller in psi, and alternating displacement in mills at both the stern of the hull in the vertical direction and at the hub of the bull gear in the longitudinal direction. This data indicates that the conversion factor (C_F) of 1.8 and the crest factor of 2.5 are reasonably satisfactory for these trials, particularly in regard to the displacement amplitudes obtained on the hull and bull gear measurements. It also indicates that the hull and machinery vibration measurements, on which the acceptance criteria are based, supports the position that the peak spectral measurements will be significantly lower than the “true” MRA obtained by the envelope method of analysis.

9.5.4 Histograms of Instantaneous Values

Some analyzers sample the signal and obtain histograms of the instantaneous values. This capability might be useful with ship vibration records, but there are several considerations. First, we are usually concerned with the amplitudes of blade-frequency and its harmonics, so that filtering is necessary as it is in the envelope method. The limitations and necessary steps in the use of the filtering of the higher harmonics will also apply to the statistical method.

Second, we are concerned with the MRA of the major frequency components. The histograms are usually obtained by sampling all the points on the record, not just the peaks. The amplitude, which is exceeded by only one or two percent of the samples, would probably involve only the tips of the largest cycles and may be comparable to the MRA. The amplitude, which is exceeded by some percentage of the samples, could be determined from the cumulative probability plot.

9.5.5 Histograms of Peak Values

This procedure would be closer to the envelope method and can be obtained with an analog to digital (A/D) converter and a microcomputer in conjunction with filters. It entails sampling the filtered signal, as described for the histograms of instantaneous values, then finding the peak (and trough) of each cycle. The peak amplitudes are then put into a histogram or cumulative probability plot. The top three, five, or ten percent of the peak amplitudes may be comparable to the MRA. Although it is not likely that this procedure is currently being used for routine analysis of ship vibration data, it would seem to be the most accurate of those discussed. However, considering the vagaries in the total scope of effort in the measurement and analysis of ship vibration, this degree of complexity would not be warranted.

TABLE 2
Examples of Alternate Vibration Measurements

	<i>Avg Spect</i> (rms)	<i>Peak Spect</i> (rms)	<i>MRA</i> (Envelop)	<i>Crest Fctr</i> ($C_F \sqrt{2}$)	<i>Conv Fctr</i> (C_F)
Hull Pressure, psi	1.3	1.65	2.65	2.04	1.45
Stem Vertical Disp., mils	1.7	.329	5.80	3.41	2.42
Bull Gear Hub, Long Disp, mils	1.87	3.22	4.79	2.56	1.81
Average					1.89

11 Measurement Report

11.1 Analysis and Reporting of Data

11.1.1 Analysis

The contents of analysis are to be selected from the following depending on the necessity:

- Severity of vibration at the propeller shaft rotational frequency for hull girder transducers
- Severity of vibration at blade rate frequencies for hull girder and machinery transducers
- Severity of vibration of each detectable harmonic of shaft rotational frequency or blade rate for hull girder and machinery transducers, as applicable. Also the severity of each detectable multiple of crankshaft rotational frequency in the case of geared diesel installations
- Severity of local structural vibration at all measurement locations
- Mode shape of local vibrations. Use hull girder vibration as reference for the mode shape.
- Severity of vibrations of local machinery or equipment at all measurement locations
- Phase relation between various transducers at blade rate, as applicable, using a suitable reference datum (e.g., a hull girder or machinery transducer or event marker)
- For diesel engines, phase relation is to be provided between all transducers measuring in the longitudinal direction and for the transducers on top of the engine measuring torsional motions; therefore, each group is to be measured simultaneously
- Severity of vibration at hull girder and machinery resonances

Note: If beating exists, it is to be noted by recording the maximum and minimum values of the amplitude and the frequency of the beat.

11.1.2 Reporting of Data

The contents of reporting are to be selected from the following depending on the objectives of the report:

- Particulars of test ship
- Particulars of propulsion-shaft system
- Particulars of main diesel engine or turbine driven plants
- Provide sketch of inboard profile of hull and superstructure;
- A lines plan
- A midship section
- A sketch of screw aperture
- A sketch showing locations of hull girder and machinery transducers and their directions of measurement. Transducer locations for local vibration measurements are to be shown on a separate sketch where the precise location of the transducer is noted.
- Trial conditions during vibration measurements including sea state, wave direction, water depth, draft at FP and AP, propeller immersion
- Plots of displacement, velocity or acceleration amplitudes versus speed for shaft rotation frequency, blade rate, or machinery excitation frequency or any harmonic thereof.
- Profiles of local deck vibration at each resonance from port to starboard and from the nearest aft to the nearest forward structural bulkhead
- Tables of all significant vibration severities and their location and frequency. Include the shaft rotational frequency for machinery-excited vibration

- Hull girder natural frequencies identified from stern measurements and any unusual vibration condition encountered
- Results of vibration measurements at local areas
- Results of vibration measurement during maneuvers
- Longitudinal vibration of the propulsion system during maneuvers
- Method of analysis of results
- Type of instrument used

The report is to note the hull natural frequencies and modes which have been identified. Also, the report is to address any undesirable or unusual vibration condition encountered.

SECTION 7 Acceptance Criteria

1 General

Criteria for assessing the acceptability of the vibration levels from vibration measurements on sea trials have matured substantially in recent years. By incorporating the international standards and industry practices, this section provides the vibration acceptance criteria covering three areas as a reference:

- i) Vibration limits for crew and passengers
- ii) Vibration limits for local structures
- iii) Vibration limits for machinery

Vibration acceptance criteria are usually defined in ship specifications. The actual vibration acceptance criteria are to be determined as appropriate based on the ship specifications and manufacturer's specifications.

3 Vibration Limits for Crew and Passengers

3.1 ABS Criteria for Crew Habitability and Passenger Comfort

The *ABS Guides for Crew Habitability and Passenger Comfort* provide acceptance criteria based on the evaluation of both sea-motion induced and mechanically-induced vibrations for the purpose of granting ABS optional notations. The acceptance criteria are stated in terms of overall frequency-weighted rms acceleration values from 0.5 to 80 Hz. Motion sickness criterion is stated as a Motion Sickness Dose Value ($MSDV_z$) for frequencies between 0.1 and 0.5 Hz.

The criteria are based on BS 6841 (1987) and ISO 2631 (1997). The frequency weighting curves in BS 6841 (1987) are used for the vertical axis (W_b filter for x -axis). The horizontal axes use the frequency weighting curves in BS 6841 and ISO 2631-1 (W_d filter for y - and z -axes). For motion sickness dose value computation, a different frequency weighting curve from BS 6841 is applied (W_f for z -axis).

The maximum weighted rms acceleration level for crew habitability is shown in Section 7, Table 1. The ABS criteria require each single axis as well as the combined multi-axes levels be less than or equal to the values expressed in Section 7, Table 1. Note that the low frequency range below 1 Hz is included to account for the human response to sea conditions including heave, slamming and whipping. The maximum weighted rms acceleration level for passenger comfort is shown in Section 7, Table 2. Again, both single axis and multi-axes levels must be less than or equal to the values expressed in Section 7, Table 2. Note that the $MSDV$ (Motion Sickness Dose Value) based on vertical motion for the frequency range of 0.1 to 0.5 Hz is also included in Section 7, Table 2.

ABS provides optional classification notations for Crew Habitability and Passenger Comfort. For details on the acceptance criteria and measurement procedure, refer to *ABS Guide for Passenger Comfort on Ships* and *ABS Guide for Crew Habitability on Ships*. Also refer to *ABS Guide for Crew Habitability on Offshore Installation* for offshore applications.

TABLE 1
Maximum Weighted RMS Acceleration Levels for Crew Habitability

<i>ABS Optional Notation</i>	<i>Frequency Range</i>	<i>Acceleration Measurement</i>	<i>Maximum Level</i>
HAB	0.5 - 80 Hz	a_w	0.4 m/s ²
HAB+	0.5 - 80 Hz	a_w	0.315 m/s ²

TABLE 2
Maximum Weighted RMS Acceleration Levels for Passenger Comfort

<i>ABS Optional Notation</i>	<i>Frequency Range</i>	<i>Acceleration Measurement</i>	<i>Maximum Level</i>
COMF	0.5 - 80 Hz	a_w	0.315 m/s ²
COMF+	0.1 - 0.5 Hz	$MSDV_z$	30 m/s ^{1.5}
	0.5 - 80 Hz	a_w	0.20 m/s ²

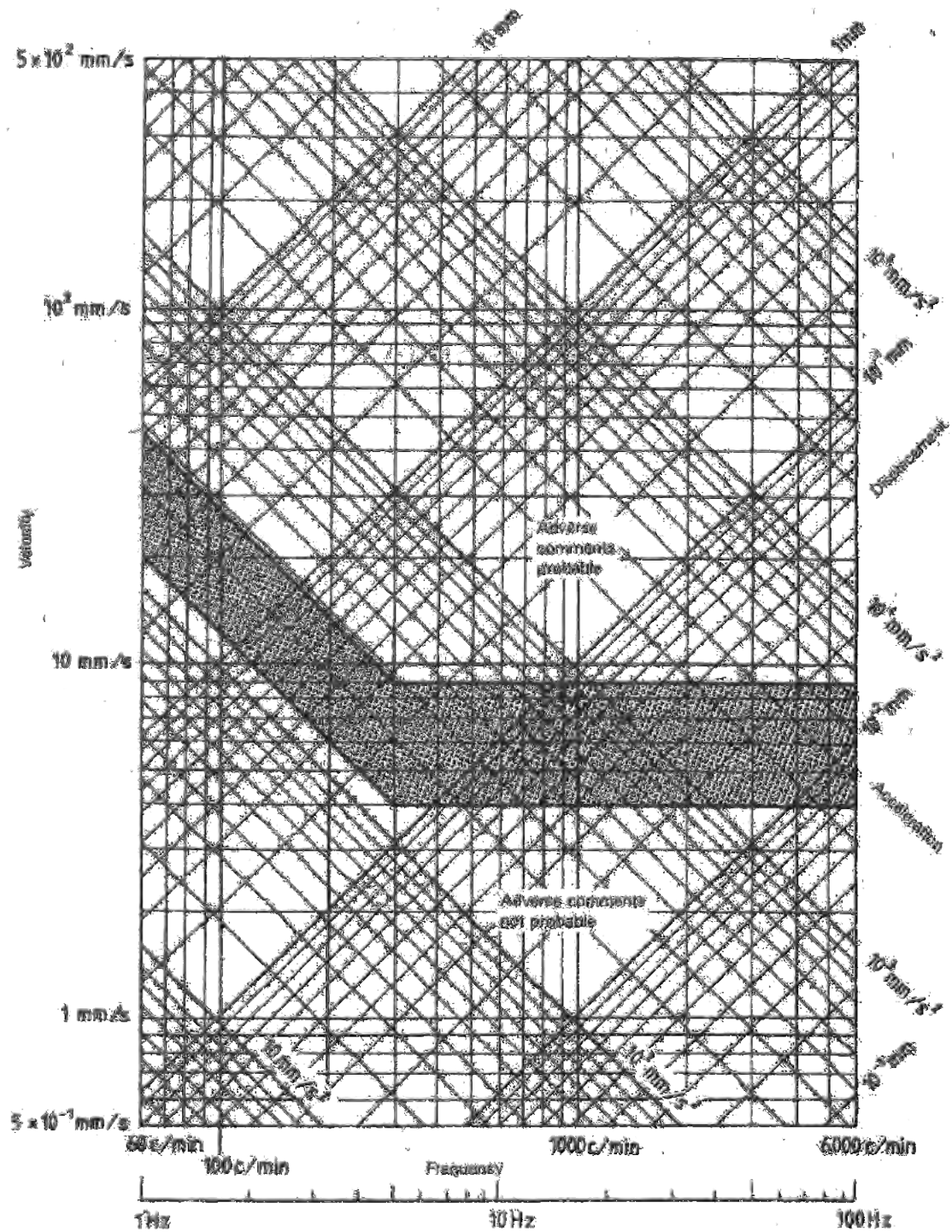
3.3 ISO 6954 (1984) Criteria for Crew and Passenger Relating to Mechanical Vibration

ISO 6954 (1984) has also been widely used as acceptance criteria for crew habitability and passenger comfort. The criteria are designed to ensure vibration levels are below at which crew and passenger do not experience discomfort. ISO 6954 criteria are shown in Section 7, Figure 1, which can be transformed into the following:

- For each peak response component (in either vertical, transverse, or longitudinal direction), from 1 Hz to 5 Hz, the acceleration is acceptable below 126 mm/sec², and adverse comment is probable above 285 mm/sec²
- For each peak response component (in either vertical, transverse, or longitudinal direction), from 5 Hz and above, the velocity is acceptable below 4 mm/sec, and adverse comment is probable above 9 mm/sec.

Criteria in the format of Section 7, Figure 1 characterizes ship vibration as a simple harmonic (i.e., periodic at a single frequency). The criteria are readily applied to the evaluation of FE-based vibration analysis, as described in Section 5. However, the ship vibration in seaways is actually random in nature (i.e., it is composed of components at all frequencies rather than at a single one). The random character of ship vibration is clearly evident in records from underway vibration surveys. Note that ISO 6954 (1984) criteria are given for the peak values considering the modulation of ship vibrations in seaways. For the measurement and evaluation of ship vibration in seaways, the Envelope method in Section 6 would be the most direct and simple method to effectively measure the peak values.

FIGURE 1
ISO 6954 (1984)



3.5 ISO 6954 (2000) Criteria for Crew and Passenger Relating to Mechanical Vibration

ISO 6954 (1984) has been revised to reflect recent knowledge on human sensitivity to whole-body vibration. The frequency weighting curves are introduced to represent human sensitivity to multi-frequency vibration for a broad range of frequencies, which are consistent with the combined frequency weighting in ISO 2631-2.

ISO 6954 (2000) provides criteria for crew habitability and passenger comfort in terms of overall frequency-weighted rms values from 1 to 80 Hz for three different areas. The simplified presentation is shown as Section 7, Table 3.

TABLE 3
Overall Frequency-Weighted RMS Values (ISO 6954: 2000)

	<i>Area Classification</i>					
	<i>A</i>		<i>B</i>		<i>C</i>	
	<i>mm/s²</i>	<i>mm/s</i>	<i>mm/s²</i>	<i>mm/s</i>	<i>mm/s²</i>	<i>mm/s</i>
Values above which adverse comments are probable	143	4	214	6	286	8
Values below which adverse comments are not probable	71.5	2	107	3	143	4

Note: The zone between upper and lower values reflects the shipboard vibration environment commonly experienced and accepted.

Area Classification A: Passenger Accommodations
 B: Crew Accommodations
 C: Work spaces

5 Vibration Limits for Local Structures

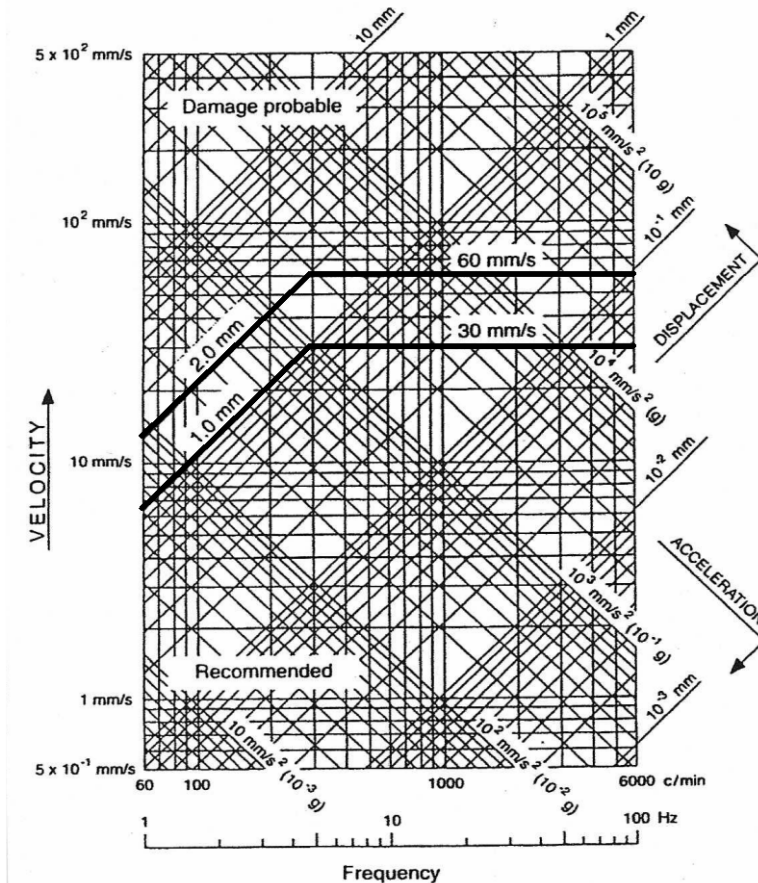
Excessive ship vibration is to be avoided in order to reduce the risk of structural damage on the local structures. Structural damage such as fatigue cracking due to excessive vibration may occur on local structures, including but not limited to engine foundation structures, engine stays, steering gear rooms, tank structures, funnels, and radar masts. It should be noted that the structural damage due to the excessive vibration vary according to the local structural detail, actual stress level and local stress concentration and material property of the local structures. Therefore, the vibration limits for local structures are to be used as a reference to reduce the risk of structural damage due to excessive vibration during the normal operating conditions.

Section 7, Figure 2 is the vibration limits for local structures, often adopted in marine industry, below which the risk of fatigue cracking due to vibration is generally expected to be low. The heavy lines are the vibration limits for local structures; recommended below the lower limit, and damage probable above the upper limit, with a “gray area” in between. Above 5 Hz, the vibration limits are specified in terms of velocity amplitude, and below 5 Hz in terms of displacement. The local structure vibrations of main interest are generally above 5 Hz. The vibration limits can be transformed into the following:

- For each peak response component (in either vertical, transverse, or longitudinal direction), from 1 Hz to 5 Hz, the displacement is recommended below 1.0 mm, and damage is probable above 2.0 mm
- For each peak response component (in either vertical, transverse, or longitudinal direction), from 5 Hz and above, the velocity is recommended below 30 mm/sec, and damage is probable above 60 mm/sec.

It is noted that the simple vibration limits described above may not be applicable to all the local structures with different structural configurations and details. In the case of tall structures and/or softly shaped structures such as masts, for example, the actual stress level due to vibration is generally small and the vibration limits of 1.0 mm or 2.0 mm may be too conservative. On the other hand, in the case of local stiffened panels with fixed ends, for example, the vibration limits of 1.0 mm or 2.0 mm may be less conservative. Therefore, the application of vibration limits for specific local structures may vary depending on the vessel specification agreed by shipyards and ship owners.

FIGURE 2
Vibration Limits for Local Structures



7 Vibration Limits for Machinery

7.1 Main Propulsion Machinery

The vibration of main propulsion machinery tends to be severe because of the excitation from the propellers. The machinery of primary concern is to be the main propulsion machinery, principally in longitudinal vibration at propeller blade rate frequency (see Section 4). The vibration criteria for the main propulsion machinery are to be provided from manufacturers. Otherwise, when the data on the vibration criteria are not available, the following criteria are recommended as a reference.

ANSI S2.27 (2002) and SNAME T&R 2-29A (2004) provide comprehensive guidelines on the vibration limits for the main propulsion machinery. The vibration limits are provided in terms of broadband rms values with multi-frequency components (nominally from 1 to 1000 Hz). The longitudinal vibration (rms, free route) at thrust bearing (and bull gear hub for geared turbine drives) is to be less than 5 mm/s rms. For other propulsion machinery components exclusive of engines, propellers and shafting aft of the thrust bearing, the longitudinal vibration is to be less than 13 mm/s rms. For stern tube and line shaft bearing, the lateral vibration is to be less than 7 mm/sec rms. For direct diesel engines (over 1000 HP, slow and medium speed diesels connected to the shafting), the vibration limits are 13 mm/sec at the bearings and 18 mm/sec on the engine tops, in all three directions. For high-speed diesel engines (less than 1000 HP), the vibration is to be less than 13 mm/sec at the bearings and engine tops, in all directions.

TABLE 4
Vibration Limits for Main Propulsion Machinery

<i>Propulsion Machinery</i>	<i>Limits (rms)</i>
Thrust Bearing and Bull Gear Hub	5 mm/s
Other Propulsion Machinery Components	13 mm/s
Stern Tube and Line Shaft Bearing	7 mm/s
Diesel Engine at Bearing	13 mm/s
Slow & Medium Speed Diesel Engine on Engine Top (over 1000 HP)	18 mm/s
High Speed Diesel Engine on Engine Top (less 1000 HP)	13 mm/s

A primary concern in the longitudinal propulsion machinery vibration is the avoidance of thrust reversal at the thrust bearing due to system longitudinal resonance, which can result in destruction of the thrust bearing. ANSI S2.27 provides the criteria on the alternating thrust at thrust bearing. During free-route runs, the broadband peak value of the alternating thrust on the main thrust bearing is to be less than 75% of the mean thrust for that speed, or less than 25% of the full power mean thrust, whichever is less.

As shown in Section 4/3, it may not be possible to avoid a longitudinal resonance in the operating range with long shaft ships. A critical at least 20% below the full power RPM is the usual practice. Even if the critical occurs at an RPM less than 20% of full power, it may be very difficult to achieve the criteria proposed by ANSI S2.27 at the resonant point, depending on the blade-rate alternating thrust amplitude and the damping present. In this case, an RPM band around the critical might have to be restricted for operation as the only reasonable recourse.

7.3 Machinery and Equipment

The vibration criteria of machinery and equipments are to be provided by manufacturers. Otherwise, when the data on the vibration criteria are not available, the following criteria are recommended as a reference in terms of overall rms value (nominally from 1 to 1000 Hz) for normal operating conditions.

- For reciprocating machinery, the vibration in all directions is to be less than 10 mm/sec rms at bearings
- For rotating machinery, the vibration in all directions is to be less than 9 mm/sec rms at bearings

The machinery includes but is not limited to generators, motors, centrifugal pumps, compressors, turbochargers, blowers and fans. The application of vibration limits may vary depending on specific type, size, configuration, and mounting of the machinery.

ISO 10816 provides guidelines on the vibration criteria in terms of overall rms values (from 2 to 1000 Hz) for the non-rotating and, where applicable, non-reciprocating parts of general machines, measured at the bearings or bearing housings. It is noted that the criteria relate only to the vibration produced by the machine itself and not to vibration transmitted to it from outside. ISO 10816 is complemented by ISO 7919, which provides guidelines on the vibration criteria for the rotating parts of the machines.

In accordance with [Appendix 7-A-14, “Surveys Based on Preventative Maintenance Techniques” of the ABS Rules for Survey After Construction \(Part 7\)](#), ABS Recognized Condition Monitoring Company is to submit the measured machinery vibration data and acceptance criteria to ABS. The vibration limits for machinery given in this section are to be used as a reference for the acceptance criteria of the Condition Monitoring Program, if applicable.



APPENDIX 1 References

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7 Measurement

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ISO 10816 (2001), Mechanical vibration – Evaluation of machinery vibration by measurements on non-rotating parts

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APPENDIX 2 Corrections

Note: This Appendix is adapted from PNA Chapter 7 (SNAME, 1988) with permission from SNAME.

1 Corrective Investigations

The approach to resolving ship vibration problems, as with most engineering problems, involves two steps. The first step is to clearly establish the cause of the problem, and the second step is to implement the changes required to eliminate it in an efficient manner.

In about 80 percent of cases the basic cause of a ship vibration problem is its propeller. Whether or not the vibration of a particular ship has its source in the propeller is easily established from underway vibration measurements. If at some shaft RPM the measured frequency of the vibration is predominantly RPM times propeller blade number, and varies directly with shaft RPM, then the propeller is definitely the exciting source. If blade-rate frequency, or its multiples, is not strongly detectable in the records, then it is almost certain that the propeller is not the primary excitation, unless the records exhibit a strong shaft-rate frequency, which could indicate propeller mechanical or hydrodynamic unbalance difficulties, but these are rather rare.

Once the excitation frequency has been established from the underway measurements, next in order is to establish whether or not resonance with structural natural frequencies plays a significant role in the magnitude of the vibration. For non-cavitating propellers, excessive hull vibration is expected to be resonant vibration. Resonant vibration is established by varying shaft RPM in steps and recording vibration amplitude successively at each RPM in the region where the problem has been identified as being most intense. If a plot of displacement amplitude versus RPM shows a definite peak with increasing RPM followed by decline, then resonant vibration is established and the position of the peak establishes the natural frequency of the resonant structural mode. If the amplitude/RPM characteristic does not peak but has an increasing trend as roughly RPM squared in the upper power range, then structural resonance is not playing a major role. If, alternatively, the amplitude/RPM characteristic increases very rapidly only in the immediate vicinity of full power without establishing a definite peak up to the maximum obtainable RPM, a full power resonance may or may not be indicated. This exhibition can be entirely the manifestation of the onset of propeller intermittent sheet cavitation, which tends to produce an almost discontinuous amplification of the hull surface excitation at the onset RPM. The sudden appearance of strong higher harmonics of blade-rate frequency in the vibration records, accompanied by violent pounding in spaces above the counter, are good indications of a full-power non-resonant vibration problem caused by excessive propeller cavitation.

If non-resonant vibration due to propeller cavitation is established, then the underway survey could probably be discontinued, with attention then turned to hydrodynamic design changes in the stern/propeller configuration. This course of action is considered in the next Subsection.

If the problem is established as highly localized resonant vibration of plating panels, piping, and the like, then the vibration survey likewise need go no further. It is usually quite obvious in such cases how natural frequency changes, through local stiffening, can be effectively and expediently accomplished to eliminate the locally resonant conditions.

If, on the other hand, the vibration problem is established as a resonant condition of a major substructure, such as a deckhouse, which has been all too often the case, then the vibration survey had best proceed to obtain mode shape information in the interest of an expeditious correction program.

3 General Approach

Just as in developing a vibration-sufficient ship design, there exist three possibilities for correcting a vibration-deficient one in normal practice:

- i) Reduce vibratory excitation
- ii) Change natural frequencies to avoid resonance
- iii) Change exciting frequencies to avoid resonance.

Most of the excessive diesel engine excited hull vibration can usually be corrected by the following provisions:

- i) Mechanical or electrical moment compensators against engine external moments, or
- ii) Engine lateral stays of weld, hydraulic or friction type against engine lateral vibration, or
- iii) Axial damper against crank shaft vibration, or
- iv) Dynamic absorber against fore-and-aft vibration of superstructure.

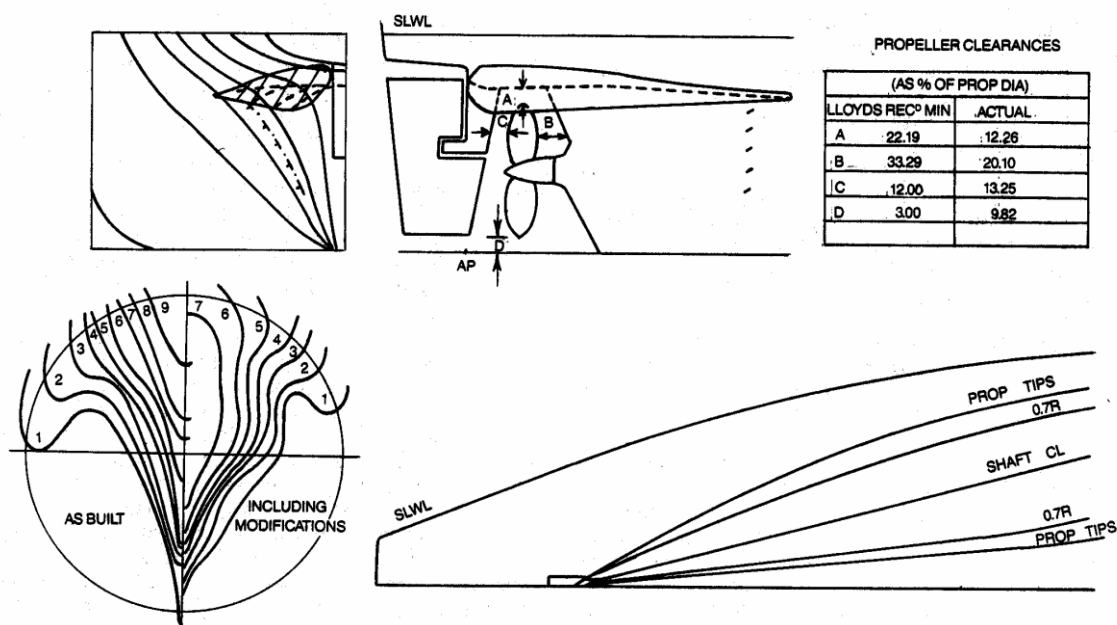
The detail information necessary for the installations of above provisions is to be provided by engine or equipment manufacturers. Otherwise the achievement of any of the three correction possibilities identified above may involve modifications in either stern/propeller hydrodynamics or hull structure.

5 Hydrodynamic Modifications

The most effective way to reduce propeller vibratory excitation is to reduce the circumferential non-uniformity of the hull wake in which the propeller operates, as discussed in detail in Section 3. In the early design stage, acceptable wakes can be achieved by taking proper care with stern lines. (Refer to Section 3/5 for the specific guidelines). In a post-design corrective situation, basic lines changes are, of course, not possible. However, with good luck in the case of poor stern lines, considerable improvements in wake might be accomplished by back fitting one of the several types of wake adapting stern appendages. The partial tunnel, Appendix 2, Figure 1, below, has been the most broadly applied of the wake adapting appendages, which also include vortex generators and wake adapting propeller ducts.

The idea is to divert the upward-aft flow along the buttock lines forward longitudinally into the upper propeller disc to reduce the wake spike near top-dead-center. This device will work most effectively on the buttock-flow type of stern; the partial tunnel was applied successfully over the years on Great Lakes ore carriers, most of which have barge-type sterns with very steep buttock angles. On the other hand, for sterns which exhibit a basically waterline-flow character, the partial tunnel would be expected to be more or less ineffective due to the lack of upward flow to divert. However, the effectiveness of the partial tunnel cannot always be accurately judged by simply classifying a prospective application as one of the two limiting cases of buttock versus waterline flow. For example, the stern shown on Appendix 2, Figure 1, from Rutherford (1978-79) might be classified as more of a waterline flow, yet the modifications shown produced significant improvement in the nominal wake, as exhibited by the before and after axial velocity contours. The contour lines on Appendix 2, Figure 1 are the lines of constant wake fraction, so that 9 is 0.9, or 10% of the axial free stream velocity, which represents a bad wake. The Appendix 2, Figure 1 modifications do however include vortex generators as well as the partial tunnel, and the contributions of each to the wake improvements shown are not known.

FIGURE 1
Wake Improvement with Special Lines-adapting Stern Devices
Conventional Stern Cargo Ship



The decision to retrofit a wake adapting stern appendage should not be made lightly without quantification of the advantages and disadvantages. A price is paid for appendages in increased hull resistance. As a minimum, model tuft-tests with and without the appendage is to be performed to observe the change in stern surface flow. The absence of any noticeable smoothing may be misleading, however, a wake survey can show improvements in the propeller plane not discernable in the tuft behavior. Furthermore, aside from nominal wake considerations, it has been found that greatest wake improvements are sometimes achieved through propeller/appendage interaction. This implies that model tuft-tests is to be conducted both with and without the operating propeller. In these cases, the best indicator of significant effective wake improvements from the standpoint of vibratory excitation may be an improvement by several percentage points in the propulsive efficiency from the model SHP test conducted with and without the wake adapting appendage. This is as explained in Hyllarides (1978).

Aside from wake improvements, the only recourse for reducing propeller excitation is modification or replacement of the propeller. Some instances of successful modifications of troublesome propellers have been reported. For example, trimming blade tips by several centimeters to reduce wake severity at the extreme propeller radii can produce improvements, but some degree of RPM increase must then be tolerated. Successful modifications of existing propellers are rare because of the usually unacceptable trade-offs of performance degradation against vibration improvement. The same disadvantages exist in propeller replacement considerations. Replacement propellers, with modified features, such as changed blade number, reduced diameter (for increased hull clearance), increased blade area, reduced pitch in the blade tips, etc., may relieve the vibration problem, but often for a dear price in vessel performance. It is unfortunate that, with the exception of moderate blade skew, essentially all of the measures available in propeller design for reducing vibratory excitation, once the stern lines are established, act also to reduce propeller efficiency. It cannot be emphasized strongly enough that the greatest insurance against propeller-induced vibration problems is to place high emphasis on wake uniformity in making trade-offs in the original establishment of vessel lines at the concept design level.

7 Structural Modifications

The most cost-effective approach for eliminating structural resonances is usually to shift natural frequencies through structural modifications. The alternative is to shift exciting frequency by changes in engine RPM or number of propeller blades.

Just as with hydrodynamics related problems, the most intelligent way to approach the correction of a vibration problem that promises to involve significant structural modifications is through the use of the tools of rational mechanics. A structural math model is to be first be calibrated to approximately simulate the existing vibration characteristics. Modification possibilities are then exercised with the model, and their probability of success is established on paper. In this way the probability of a “one-shot” success when shipboard modifications are subsequently implemented is maximized. The alternative and unenlightened “cut-and-try” approach to the solution of serious ship vibration problems is fraught with frustration, and with the possibility of expending vast amounts of time and money without achieving complete success.

Of course, the paper-studies proposed as a tool for use in correcting a serious ship vibration problem must be concluded quickly. Several months, or even several weeks, is not available when delivery of a vessel is stalled, awaiting the resolution of vibration deficiencies. This places a premium on formulation of the simplest possible structural models which still retain adequate realism to provide the basis for the required judgments as to the relative effects of vessel modifications. This is where the collection of thorough trial vibration data can pay for itself. Measurement of vibratory mode shape data is often a near necessity for securing guidance in formulating calibration models of the desired simplicity, but with sufficient accuracy. This is illustrated by the following case study.

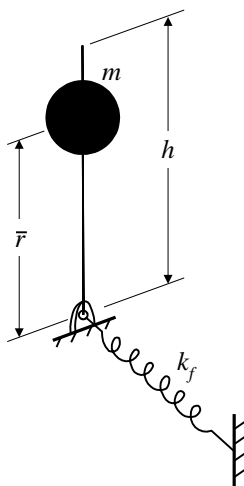
9 Case Study

Excessive vibration of a Type A deckhouse, Section 4, Figure 4, occurs on the builder’s trials of an 80,000 DWT product carrier. Vibratory displacement amplitude data are recorded with a multi-channel recorder via phase-calibrated accelerometers mounted at points on the house and on the main deck. The records establish the following information.

- i) The vibration occurs at predominantly blade-rate frequency, confirming the propeller as its exciting source.
- ii) The vibration amplitude peaks at 100 RPM, and the propeller has five blades. A resonance of the house at 500 cycles per min (cpm) is therefore established.
- iii) Vibration records recorded at 100 RPM show that the vibration of the house is predominantly fore-and-aft, with fore-and-aft amplitude increasing with a quasi-linear characteristic from low levels at main deck to a maximum of 39 mm/sec at the housetop. The housetop is 15 meters above main deck.
- iv) The 100 RPM record also shows that the amplitude of the vertical vibration at main deck is approximately uniform at $V = \omega X = 5$ mm/sec over the house length. The vertical vibration amplitude is also approximately constant at this same level up the house front, which is a continuation of the forward engine room bulkhead.

The above measured characteristics of the vibration under consideration are judged to allow the use of the simple rocking/bending house model in conjunction with the Hirowatari method, Subsection 4/7, Section 4, Figures 4 and 5 and Section 4, Table 2.

FIGURE 2
Mass-elastic Model of Deckhouse and Support Structure



9.1 Determination of Model Constants

For a Type A house with $h = 15$ meters, the fixed-base fundamental house natural frequency is estimated from Section 4, Figure 5 as $f_{\infty} = 800$ cpm. Using the Dunkerley formula in Section 4 with the measured house natural frequency $f_e = 500$ cpm, the effective rocking frequency is predicted to be,

$$f_R = \sqrt{\frac{1}{1/f_e^2 - 1/f_{\infty}^2}} = 640 \text{ cpm}$$

The two frequencies f_{∞} and f_R can be used to determine the effective stiffness of the house and its under-deck supporting structure for use in the simple model of Appendix 2, Figure 2. For a house mass established as $m = 300$ t, with a radius of gyration, r , about the house forward lower edge of 10 m, the effective torsional stiffness of the under-deck supporting structure is, from Subsection 4/7:

$$K_f = (2\pi/60)^2 f_R^2 J = 1.35 \times 10^{11} \text{ N-m/rad}$$

where

$$J = m \bar{r}^2 = 3 \times 10^7 \text{ kg-m}^2$$

An approximate effective bending/shear stiffness of the house, K_h , is obtained by first lumping the house mass at the radius of gyration above the assumed pin support on the main deck at the forward bulkhead. This preserves the mass moment of inertia in the Appendix 2, Figure 2 model. Then, for the house base fixed,

$$K_h = (2\pi/60)^2 f_{\infty}^2 m = 2.1 \times 10^9 \text{ N/m}$$

The effective combined torsional stiffness for use in the equivalent reduced one-mass system is then:

$$K = \frac{1}{1/K_f + 1/(K_h \bar{r}^2)} = 0.822 \times 10^{11} \text{ N-m/rad} \dots\dots\dots (\text{A2.1})$$

This combined stiffness can also be deduced directly from the measured natural frequency and the house mass moment of inertia as:

$$K = (2\pi/60)^2 f_e^2 J = 0.822 \times 10^{11} \text{ N-m/rad}$$

The effective exciting moment due to the vertical hull girder vibration can be estimated using the following formula:

$$M_e = \omega m \bar{\xi} V \dots\dots\dots (A2.2)$$

Here, ωV is the vertical acceleration of the house via the hull girder, so that $m\omega V$ is a vertically downward inertia force acting at the house CG. $\bar{\xi}$ is the longitudinal coordinate to the house CG, measured aft from the house front, which is 5 m. V is the velocity amplitude of the main deck vertical vibration, which is 5 mm/sec. In terms of arbitrary hull girder vibration frequency ω , the exciting moment is estimated as:

$$M_e = 150\omega^2 \text{ N-m}$$

As a final remaining element of the Appendix 2, Figure 2 equivalent one-mass model, the damping factor ζ , is estimated as follows using the measured 39 mm/sec house top vibration amplitude. With Φ being the amplitude of the equivalent vibratory rocking angular velocity of the house, the fore-and-aft velocity amplitude of the housetop is approximated as,

$$U = \Phi h$$

where h is the 15 m house height above main deck. Substituting the response formula for the Appendix 2, Figure 2 model,

$$U = \frac{\omega h M_e / K}{\sqrt{[1 - (\omega / \omega_n)^2]^2 + (2\zeta \omega / \omega_n)^2}} \dots\dots\dots (A2.3)$$

But at resonance, $\omega = \omega_n$, so that:

$$U = \frac{\omega h M_e / K}{2\zeta} = 39 \text{ mm/sec} \dots\dots\dots (A2.4)$$

or

$$\zeta = \frac{\omega h M_e}{2 K U}$$

For $\omega = \omega_n = 2\pi f / 60 = 52.4 \text{ rad/sec}$,

$$M_e = 4.12 \times 10^5 \text{ N-m}$$

The damping factor is then,

$$\zeta = \frac{52.4 \times 15 (4.12 \times 10^5)}{2 (0.822 \times 10^{11}) (39 \times 10^{-3})} = 0.05$$

With the calibrated model so established as an equivalent one degree of freedom system, with constants, J , K , ζ and M , the above formula can be reused to evaluate changes in the house-top vibratory velocity amplitude, U , resulting from selected changes in the array of design variables included in the simple formulation.

9.3 Structural Rectification Analysis

To demonstrate the procedure, stiffening in the form of the added parallel pillars of the Section 4, Figure 6 example is contemplated. Following that example, the torsional stiffness of the under-deck supporting structure is raised from the above value of $1.35 \times 10^{11} \text{ N-m/rad}$ to $1.475 \times 10^{11} \text{ N-m/rad}$ by the pillar addition. From Equation A2.1, the increased combined stiffness of $K = 0.866 \times 10^{11} \text{ N-m/rad}$ results in a 2.6 percent increase in natural frequency from the measured value of 500 cpm to 513 cpm. The full power RPM of the vessel is 105, which corresponds to a full power blade-rate exciting frequency of 525 cpm. The critical has therefore been raised only to a higher level in the operating range from 100 to 102.6 RPM.

At 102.6 RPM, the 5 mm/sec vertical hull girder vibration measured at 100 RPM would be increased by at least the frequency increase cubed, since the propeller exciting force would vary as RPM squared. This is assuming a flat frequency response characteristic of the hull girder (not close to a hull girder critical) as well as a non-cavitating propeller. Assuming a frequency cubed increase in V , the hull girder vertical vibration velocity amplitude becomes,

$$V = 5(102.6/100)^3 = 5.4 \text{ mm/sec}$$

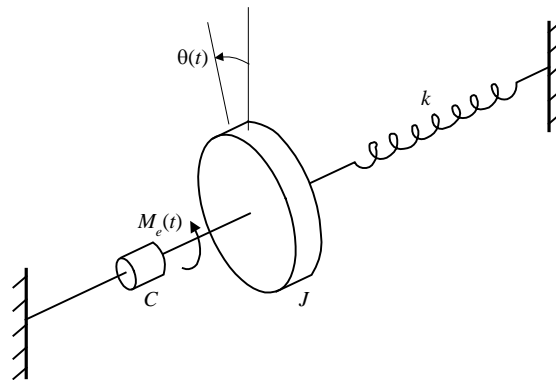
which would still be quite acceptable. However, the exciting moment from Equation A2.2 would be increased to:

$$M_e = 4.56 \times 10^5 \text{ N-m}$$

at the new resonant frequency $\omega = \omega_n = (2\pi)(513/60) = 53.72 \text{ rad/sec}$. The house top fore-and-aft vibratory velocity amplitude resulting from the foundation stiffening, assuming the damping factor unchanged, is predicted to be increased from 39 mm/sec to:

$$U = \frac{53.72 \times 15 (4.56 \times 10^5) / 0.866 \times 10^{11}}{2(0.05)} = 40 \text{ mm/sec}$$

FIGURE 3
Equivalent One-mass System



This is an increase in vibration of 2.5 percent over the original 39 mm/sec level. The inadequate stiffening has simply raised the critical to a higher point in the operating range where the excitation is more intense. Some care is required here in order to achieve a satisfactory result.

In view of the above result, it would be intelligent at this point to evaluate the stiffness increase required in order to achieve a satisfactory vibration level. It is most desirable to move the critical above the full power RPM of 105, rather than decreasing stiffness to get below it. This establishes the exciting frequency at the full power RPM:

$$f = 525 \text{ cpm} = 8.75 \text{ Hz}$$

$$\omega = 8.75(2\pi) = 55 \text{ rad/sec}$$

For crew accommodation areas, the limiting housetop fore-and-aft vibratory velocity amplitude of 5 mm per sec is selected at this frequency. Continuing to assume a frequency-cubed variation in the hull vertical velocity amplitude, the exciting moment is now from Equation A2.2:

$$M_e = (55)(3 \times 10^5)(5)(5)(525/500)^3/1000 = 4.775 \times 10^5 \text{ N-m}$$

From Equation A2.3, for $2\zeta\omega/\omega_n \ll [1 - (\omega/\omega_n)^2]$ for $\omega/\omega_n < 1$:

$$U = \frac{\omega h M_e / K}{1 - (\omega / \omega_n)^2} \dots\dots\dots (A2.5)$$

Then with $\omega_n = \sqrt{K/J}$, the required combined stiffness is:

$$K = \omega h M_e / U + J \omega^2$$

Substituting the values, the required combined stiffness is:

$$K = 1.7 \times 10^{11} \text{ N-m/rad}$$

This requires more than doubling the as-built combined effective stiffness of 0.822×10^{11} N-m/rad. Little can normally be done to change the house stiffness; functional requirements of the house usually will not permit the modifications necessary to accomplish any significant increases in house casing section moment of inertia and shear area. Stiffening of the under-deck supporting structure is the only and possibly effective structural modification that can be accommodated. The required K_f is, from Equation A2.1:

$$K_f = \frac{1}{1/K - 1/K_h \bar{r}^2} = 1.02 \times 10^{12} \text{ N-m/rad}$$

Therefore, meeting the vibration limit of 5 mm/sec at the housetop will require increasing the effective torsional stiffness of the under-deck supporting structure by a factor of:

$$\frac{1.02 \times 10^{12}}{1.35 \times 10^{11}} = 7.5$$

and this would be impossible to accomplish. For example, if the two parallel pillars of the Subsection 4/7 example were doubled in number from 2 to 4 and moved 3 meters aft to line up under the house after bulkhead, rather than under the house sides (Section 4, Figure 6), K_f would be increased to only:

$$\begin{aligned} K_f &= 1.35 \times 10^{11} + 2(5 \times 10^8)(8)^2 \\ &= 1.99 \times 10^{11} \text{ N-m/rad} \end{aligned}$$

which is still a factor of more than 5 below the required value. At this point, the virtual impossibility of rectifying the problem through structural modifications is clear, and attention would be turned to the propeller.

9.5 Propeller Change

Considering an alternative 4-bladed propeller, the critical would be shifted to:

$$100(5/4) = 125 \text{ RPM}$$

which is 25% above the critical, which meets the rule of thumb. With the foundation unchanged, the housetop vibration at the full power RPM of 105 would be, from Equation A2.5:

$$U = \frac{(55)15(4.775 \times 10^5)/0.822 \times 10^{11}}{1 - (105/125)^2} \times 1000 = 16 \text{ mm/sec}$$

The vibration at the housetop is down by almost 50%, but still too high, on the basis of the habitability criterion. Another possibility for the propeller would be to change to 6 blades and lower the critical below full power to:

$$100(5/6) = 83 \text{ RPM}$$

At full power in this case:

$$U = \frac{(55)15(4.775 \times 10^5)/0.822 \times 10^{11}}{|1 - (105/83)^2|} \times 1000 = 8 \text{ mm/sec}$$

This level might be judged to be marginally acceptable as a workspace on the bridge deck at the top of the deckhouse. The disadvantage to 6 blades is the resonance at 83 RPM. At 83 RPM (43.5 rad/sec), the exciting moment, Equation A2.2, goes down by at least frequency cubed, as has been previously assumed.

$$M_e = 4.775 \times 10^5 (83/105)^3 = 2.36 \times 10^5 \text{ N-m}$$

With 6 blades, $f_e = 6(83)/60 = 8.3$ Hz (52.2 rad/sec). The resonant amplitude is from Equation A2.4,

$$U = \frac{(52.2)15(2.36 \times 10^5)/0.822 \times 10^{11}}{2(0.05)} \times 1000 = 22.5 \text{ mm/sec}$$

While this predicted level is excessive, it would not necessarily disqualify a 6-bladed propeller, as continuous operation at any particular lower RPM is usually not critical, and 83 RPM could be simply avoided except in passing.

In this case study, it was decided to change to a 6-bladed propeller. A reconditioned propeller of the correct diameter and pitch was refitted on the vessel. It was confirmed in advance that the blade area met the Burrill Criteria 10% back cavitation as suggested at Figure 5 of Section 4. The deckhouse vibration was judged by the owner to be acceptable in closely enough meeting the habitability criteria from Table 3. A vibration increase in passing through the 80-85 RPM range was detectable by personnel in the deckhouse but it was quite moderate and judged also to be acceptable. Successful acceptance trials were completed within the delivery guarantee margin mandated by the contract.



APPENDIX 3 Seaway Excitation and Response

1 General

Ship flexural vibration excited by the seaway can be of three types:

- i) Springing
- ii) Bow Flare Slamming
- iii) Bottom Slamming

3 Springing

Springing is a continuous-type vibration of the hull excited by the short wave (high frequency) wave components of the seaway. This is versus transient slamming, which is addressed in the next Subsection. The most well-known cases of springing were with the Great Lakes Ore Carriers built in the 1970's. There, the locks limitations on vessel beam and depth required longer and longer shiplength to meet desired cargo capacity. Therefore, the ships had a very low 2-noded vertical flexural natural frequency. This coupled with the short-length (high frequency) spectrum of the Great Lakes seaway, resulted in measurable response magnification in the first flexural mode. The level of the flexural response could, however, not be explained by sub-resonant magnification alone. It was concluded by ABS that nonlinear hydrodynamics in producing low frequency "difference wave" excitation also played a role. Although monitored carefully for some years, no failures of the Great Lakes bulk carriers have ever been attributed to springing.

Springing could however be brought back to the forefront of attention by increasing vessel speed. The higher the speed the higher the "frequency of encounter" with the sea waves. The result could be the same as appeared on the Great Lakes 30 to 40 years ago, but for a different reason. Care needs to be exercised in designing the new generation of high-speed ships with enough hull girder stiffness to avoid significant dynamic magnification of hull flexure by high frequency of encounter relative to sea waves.

5 Bow Flare Slamming and Whipping

Bow flare slamming occurs due to flattening of the bow (and stern) lines toward horizontal in the vessel body plan. Here the bow flare slamming tends to be more continuous and of longer duration than fore-foot bottom impact slamming. Therefore, for large container carriers as a typical example, the bow flare slamming can produce significant transient hull girder vibratory response called 'whipping', which usually cause the amplification of global hull girder bending loads. The bow flare slamming is also known to be capable of producing local damage to bulwarks and side plating in the flare regions.

The inclination is to add flare in the bow to provide the hydrodynamic stiffness to avoid bow submergence in the waves. But the price paid in bow deceleration to prevent submergence is high flare loads and potential structural damage, both globally and locally.

Usual practice is that with high-speed ships, flare angles of the bow side shell and bulwarks are not to exceed angles of 40 to 45 degrees relative to the vertical.

7 Bottom Impact Slamming

Emergence of the fore-foot bottom above the water surface followed by reentry tends to produce very intense slamming that occurs for a short duration (fractions of a second). Here the essentially instantaneous application of basically a point force will excite the ship to “ring” in all of its normal modes simultaneously, but to different degrees of course, depending on the spectral content of the slam impulse. This can be particularly serious with very low natural frequency substructures base excited through the transients from the hull girder. It can also produce local plating damage in the fore-foot due to the high hydrodynamic impact pressure loadings.

Aside from designing for a deep forefoot, the best protection against bottom slamming damage is the adjustment of seaway operations to suit the local sea characteristics.

APPENDIX 4 Concept Design Checklist

The following provides a summary of the check list that is to be encountered in the typical concept design process:

- i)* During the initial engine selection, check the 2nd order vertical moment M_{2v} from potential vendor, by the procedure of Subsection 3/3. If the PRU (Power Related Unbalance) exceeds 220 N-m/kW, consider either change of engine selection or installation of moment compensators. Also the installation of engine lateral stays on the engine room structure is to be addressed at the early design stage
- ii)* During the initial stern lines fairing and propulsion system arrangement studies, check the maximum angles and minimum propeller clearances in Section 3, Figure 5 or 6.
- iii)* Check if the aperture clearance provided in *ii)* is adequate to accommodate a propeller diameter satisfying the Burrill cavitation criteria for a maximum of 10% back cavitation, in Section 3, Figure 8.

If either *ii)* or *iii)* are not satisfied, plans is to be made to perform detailed wake and propeller cavitation studies based on model testing and/or numerical simulation.

- iv)* Once preliminary hull principal dimensions and weight are established, check the vertical hull girder natural frequencies up to at least 5 nodes to avoid the resonance or near resonance (20% separation minimum) with the engine second-order vertical moment at full power. This is by the procedure of Subsection 4/3.

If twice the RPM of the engine at full power falls within 20% of any of the estimated natural frequencies, the more precise FE-based free vibration analysis of the hull girder natural frequencies is recommended.

- v)* At the time of propulsion machinery and foundation arrangement design, follow the procedure of Subsection 4/5 to check the thrust bearing structural foundation stiffness needed to avoid blade-rate resonance with either of the first two system longitudinal natural modes in the upper power range.

If this cannot be achieved, the change of propeller blade number and/or RPM is to be considered so that a minimum 20% margin on the full power PRPM is provided.

- vi)* In developing the scantlings and supporting structure of the deckhouse, perform the analysis of Subsection 4/7 to avoid fore-and-aft blade-rate resonance, within the 20% margin at full power.

BAB V

KESIMPULAN DAN SARAN

5.1 KESIMPULAN

1. Menganalisa sumber getar pada kamar mesin dapat dilakukan menggunakan dua cara, yaitu dengan perhitungan secara manual berdasarkan desain atau data yang telah ada. Serta dengan pengukuran secara langsung pada kamar mesin pada titik yang telah ditentukan.
2. Nilai amplitudo ekstiasi pada getaran longitudinal hasil dari perhitungan secara manual, yaitu sebesar 0,217 kN. Masih memenuhi standar yang berlaku pada ABS (*American Bureau of Shipping*), dimana tidak melebihi dari 0,3762 kN.
3. Nilai osilasi torsi pada getaran torsional hasil dari perhitungan secara manual, yaitu sebesar 0,0127 kN. Masih memenuhi standar yang berlaku pada ABS (*American Bureau of Shipping*), dimana tidak melebihi dari 0,016 kN.
4. Berdasarkan data hasil pengukuran secara langsung pada 20 titik objek percobaan didapatkan bahwa nilai tingkat getaran diseluruh titik objek pengukuran masih memenuhi standar yang berlaku pada ABS (*American Bureau of Shipping*).
5. Berdasarkan data hasil pengukuran secara langsung pada 20 titik. Didapatkan bahwa getaran terbesar terjadi pada titik no.11 atau *clutch* no. 1, yaitu sebesar 5,66 mm/s
6. Berdasarkan rata-rata dari data hasil pengukuran secara langsung pada 20 titik yaitu $1,22 \text{ m/s}^2$. Didapatkan bahwa nilai tingkat getaran terhadap tubuh manusia tidak

memenuhi standar yang berlaku pada ABS (*American Bureau of Shipping*), dimana melebihi $0,4 \text{ m/s}^2$.

7. Berdasarkan rata-rata dari data hasil pengukuran secara langsung pada 20 titik yaitu $1,22 \text{ m/s}^2$. Didapatkan bahwa nilai tingkat getaran terhadap tubuh manusia, mendapat kategori “*uncomfortable*” pada standar ISO 2631.
8. Berdasarkan rata-rata dari data hasil pengukuran secara langsung pada 20 titik yaitu $1,22 \text{ m/s}^2$. Didapatkan bahwa nilai tingkat getaran terhadap tubuh manusia masih memenuhi standar yang berlaku pada Keputusan Menteri Tenaga Kerja Republik Indonesia No.19 Tahun 1999, dimana masih dibawah nilai 4 m/s^2 .
9. Nilai tegangan poros akibat getaran torsional hasil dari perhitungan secara manual, yaitu sebesar $38,98 \text{ N/mm}^2$ pada saat kondisi operasi kontinyu, masih memenuhi standar, dimana sebesar $\pm 27-42 \text{ N/mm}^2$. Dan pada saat kondisi operasi sementara sebesar $66,268 \text{ N/mm}^2$, masih memenuhi standar, dimana sebesar $\pm 56-74 \text{ N/mm}^2$. Sehingga poros yang digunakan pada KMP. Dharma Rucitra masih memenuhi standar yang berlaku pada BKI (*Biro Klasifikasi Indonesia*) Vol. III, mengenai *Stress Torsional Vibration*.

5.2 SARAN

1. Titik pengukuran no. 11 atau *clutch* no.1 perlu mendapatkan perhatian lebih, karena tingkat getarannya cukup tinggi ($5,66 \text{ mm/s}$) dibandingkan dengan titik-titik pengukuran lainnya.
2. Analisa lebih lanjut mengenai dampak gelombang laut terhadap getaran sistem propulsi.

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BIODATA PENULIS



Gathot Dwi Laksono, merupakan anak tunggal dari pasangan Kusri dan Djati Susanawati. Lahir di Jakarta pada tanggal 28 September 1993. Selama hidupnya pendidikan yang telah ditempuhnya antara lain: SD Jatiasih VIII, SMPN 12 Bekasi, dan

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